



(12) **United States Patent**
Steinebach et al.

(10) **Patent No.:** **US 10,407,011 B2**
(45) **Date of Patent:** **Sep. 10, 2019**

(54) **CAST BUMPER SYSTEM AND METHOD OF MANUFACTURING SAME**

(71) Applicants: **Edward Karl Steinebach**, Oak Ridge, TN (US); **Jeremiah John Brady**, Knoxville, TN (US); **Jeffrey Jay Mellis**, Bloomfield Hills, MI (US); **Richard Lee Winfree**, Knoxville, TN (US); **Mark Justin Jones**, Knoxville, TN (US); **Darren Andrew Womack**, Windsor (CA)

(72) Inventors: **Edward Karl Steinebach**, Oak Ridge, TN (US); **Jeremiah John Brady**, Knoxville, TN (US); **Jeffrey Jay Mellis**, Bloomfield Hills, MI (US); **Richard Lee Winfree**, Knoxville, TN (US); **Mark Justin Jones**, Knoxville, TN (US); **Darren Andrew Womack**, Windsor (CA)

(73) Assignee: **MAGNA INTERNATIONAL INC.**, Aurora (CA)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 25 days.

(21) Appl. No.: **15/784,113**

(22) Filed: **Oct. 14, 2017**

(65) **Prior Publication Data**

US 2018/0037179 A1 Feb. 8, 2018

Related U.S. Application Data

(63) Continuation-in-part of application No. 15/386,135, filed on Dec. 21, 2016, which is a (Continued)

(51) **Int. Cl.**

B60R 19/18 (2006.01)

B60R 19/34 (2006.01)

(Continued)

(52) **U.S. Cl.**

CPC **B60R 19/18** (2013.01); **B22D 25/02** (2013.01); **B23K 31/02** (2013.01); **B60R 19/023** (2013.01);

(Continued)

(58) **Field of Classification Search**

CPC B60R 19/02; B60R 19/023; B60R 19/03; B60R 19/18; B60R 19/26; B60R 19/34

(Continued)

(56) **References Cited**

U.S. PATENT DOCUMENTS

5,785,367 A * 7/1998 Baumann B60R 19/18 293/133

5,969,548 A 10/1999 Knapp (Continued)

FOREIGN PATENT DOCUMENTS

EP 1640147 A1 3/2006

EP 2284045 A1 2/2011

(Continued)

OTHER PUBLICATIONS

International Search Report; PCT/US2018/55783; dated Dec. 31, 2018; 9 pages.

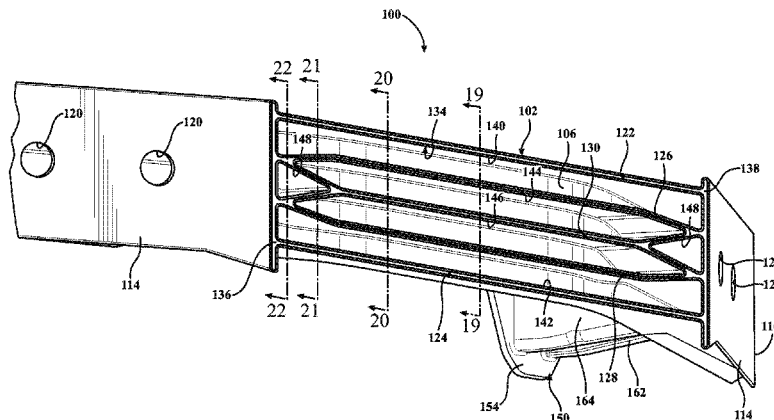
Primary Examiner — Jason S Daniels

(74) *Attorney, Agent, or Firm* — Dickinson Wright PLLC

(57) **ABSTRACT**

A bumper system including a bumper beam being cast from metal having a front panel and a back panel, extending between a first bumper beam end and a second bumper beam end. A plurality of reinforcing ribs integrally cast with the bumper beam extends between the front panel and the back panel defining a non-uniform cross-sectional profile along a portion of the bumper beam. The front panel includes a front center portion disposed between a pair of front side portions. The back panel includes a back center portion disposed between a pair of back side portions. The front center portion

(Continued)



has a front center portion thickness greater than a back center portion thickness. Each of the front side portions has a front side portion thickness being less than a back side portion thickness of adjacent one of the back side portions. Method of manufacturing the bumper system is provided.

21 Claims, 17 Drawing Sheets

Related U.S. Application Data

- continuation-in-part of application No. 15/319,878, filed as application No. PCT/US2015/039596 on Jul. 8, 2015.
- (60) Provisional application No. 62/022,366, filed on Jul. 9, 2014.
- (51) **Int. Cl.**
B60R 19/02 (2006.01)
B22D 25/02 (2006.01)
B23K 31/02 (2006.01)
B60R 19/03 (2006.01)
B23K 101/00 (2006.01)
B23K 101/28 (2006.01)
B23K 103/04 (2006.01)
B23K 103/08 (2006.01)
B23K 103/18 (2006.01)
B23K 103/20 (2006.01)
- (52) **U.S. Cl.**
 CPC *B60R 19/03* (2013.01); *B60R 19/34* (2013.01); *B23K 2101/006* (2018.08); *B23K 2101/28* (2018.08); *B23K 2103/04* (2018.08); *B23K 2103/15* (2018.08); *B23K 2103/18* (2018.08); *B23K 2103/20* (2018.08); *B60R 2019/1813* (2013.01)

- (58) **Field of Classification Search**
 USPC 293/132, 133
 See application file for complete search history.

(56) **References Cited**

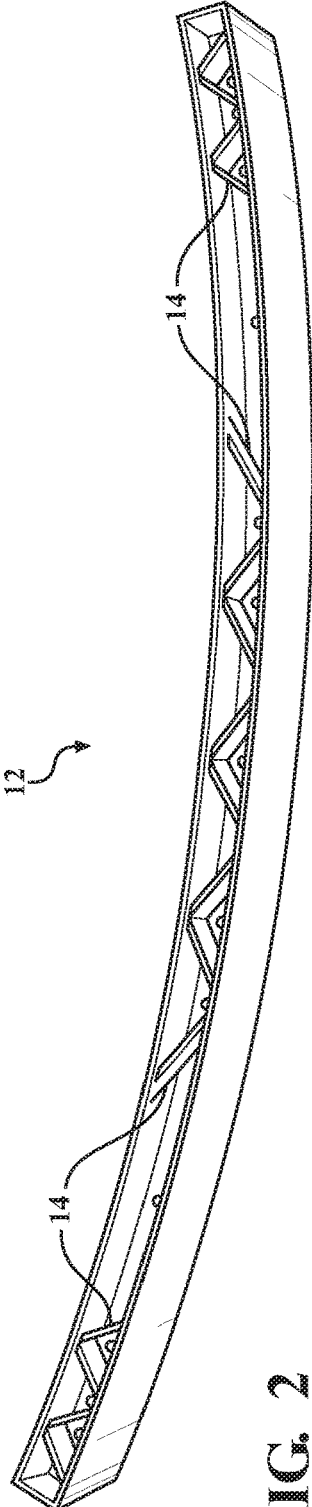
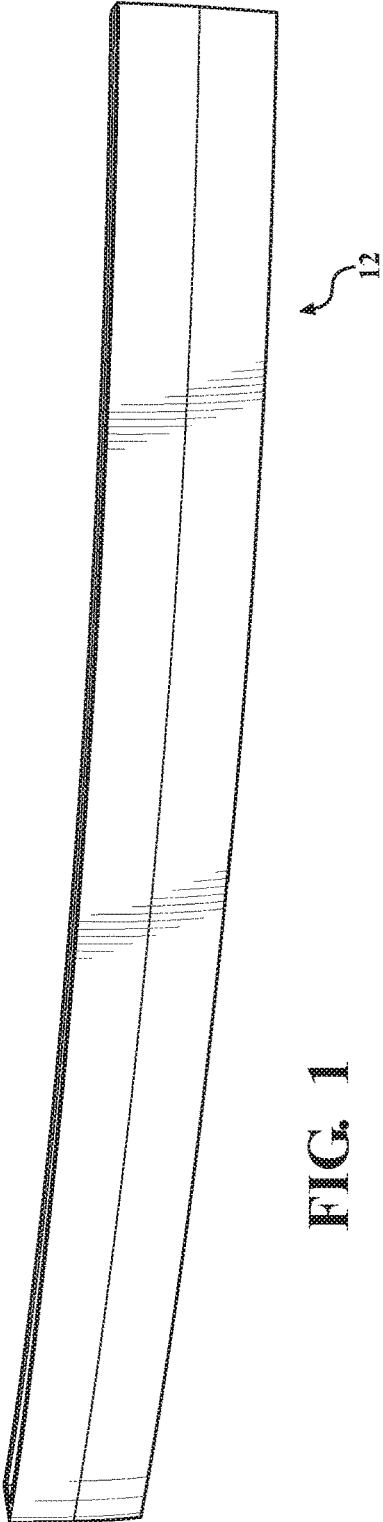
U.S. PATENT DOCUMENTS

6,318,775	B1	11/2001	Heatherington et al.	
7,390,038	B2	6/2008	Campbell et al.	
7,837,230	B2	11/2010	Mellis et al.	
7,959,197	B2	6/2011	Agrahari et al.	
9,156,417	B2 *	10/2015	Mori	B60R 19/34
2003/0057692	A1	3/2003	Horsch et al.	
2005/0104392	A1	5/2005	Liebhart et al.	
2007/0056819	A1	3/2007	Kano et al.	
2007/0114804	A1	5/2007	Gross et al.	
2007/0271793	A1	11/2007	Mellis et al.	
2008/0012386	A1	1/2008	Kano et al.	
2008/0308196	A1	12/2008	Chung	
2009/0026799	A1	1/2009	Garilov	
2010/0126813	A1	5/2010	Hayashi	
2011/0187135	A1	8/2011	Kano et al.	
2012/0025547	A1	2/2012	Haneda et al.	
2012/0205927	A1	8/2012	Asakawa et al.	
2013/0157073	A1	6/2013	Charest et al.	
2013/0234456	A1	9/2013	Brockhoff et al.	
2017/0106822	A1	4/2017	Steinebach et al.	
2017/0182960	A1 *	6/2017	Nakajima	B60R 19/18
2017/0203707	A1	7/2017	Fuerst et al.	

FOREIGN PATENT DOCUMENTS

JP	2008296716	A	12/2008
JP	2010120026	A	6/2010
JP	2011179579	A	9/2011
WO	2016007661	A1	1/2016
WO	2017021856	A1	2/2017

* cited by examiner



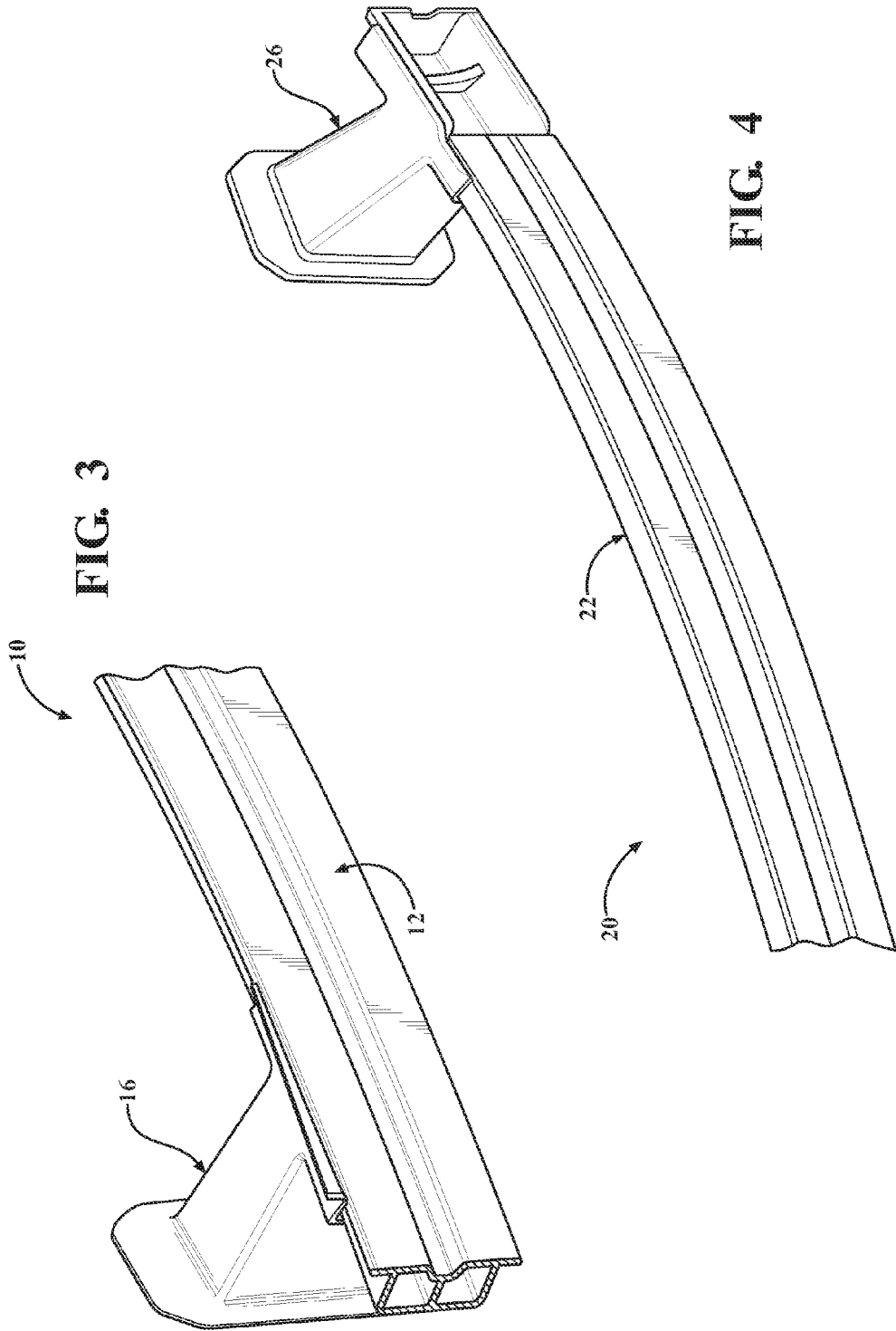
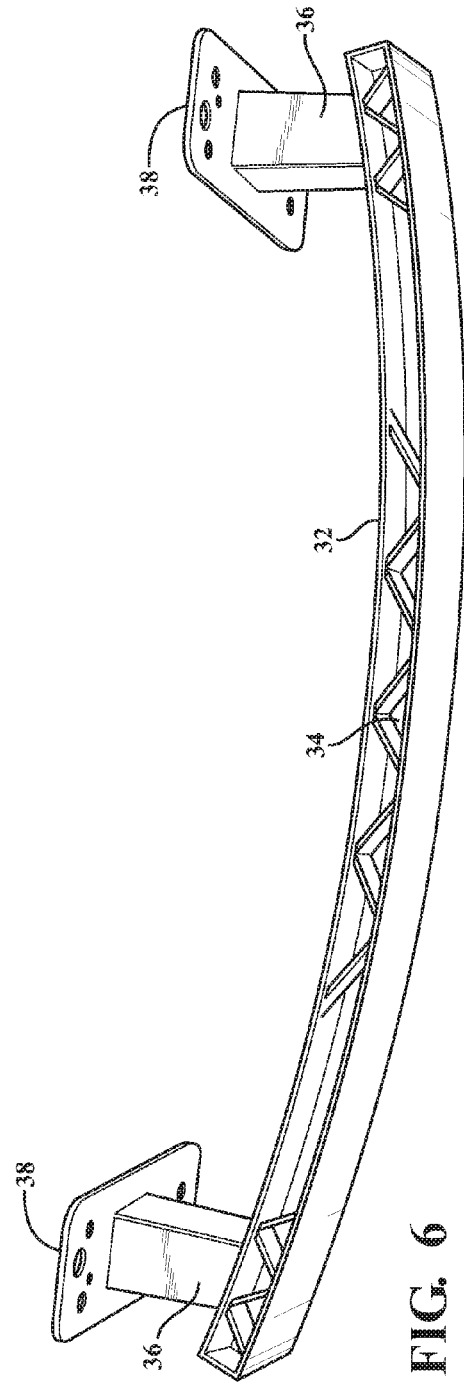
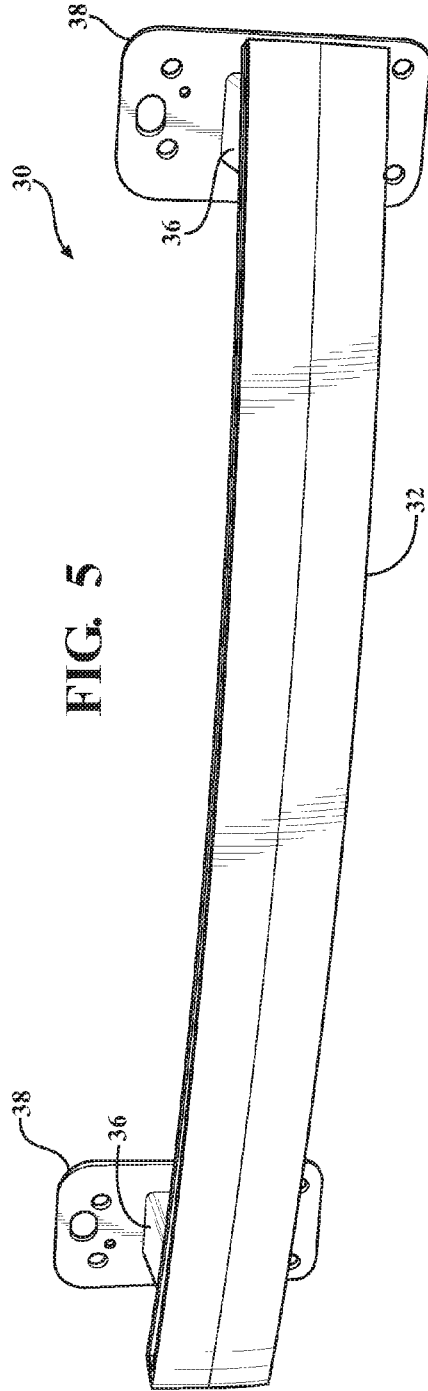


FIG. 3

FIG. 4



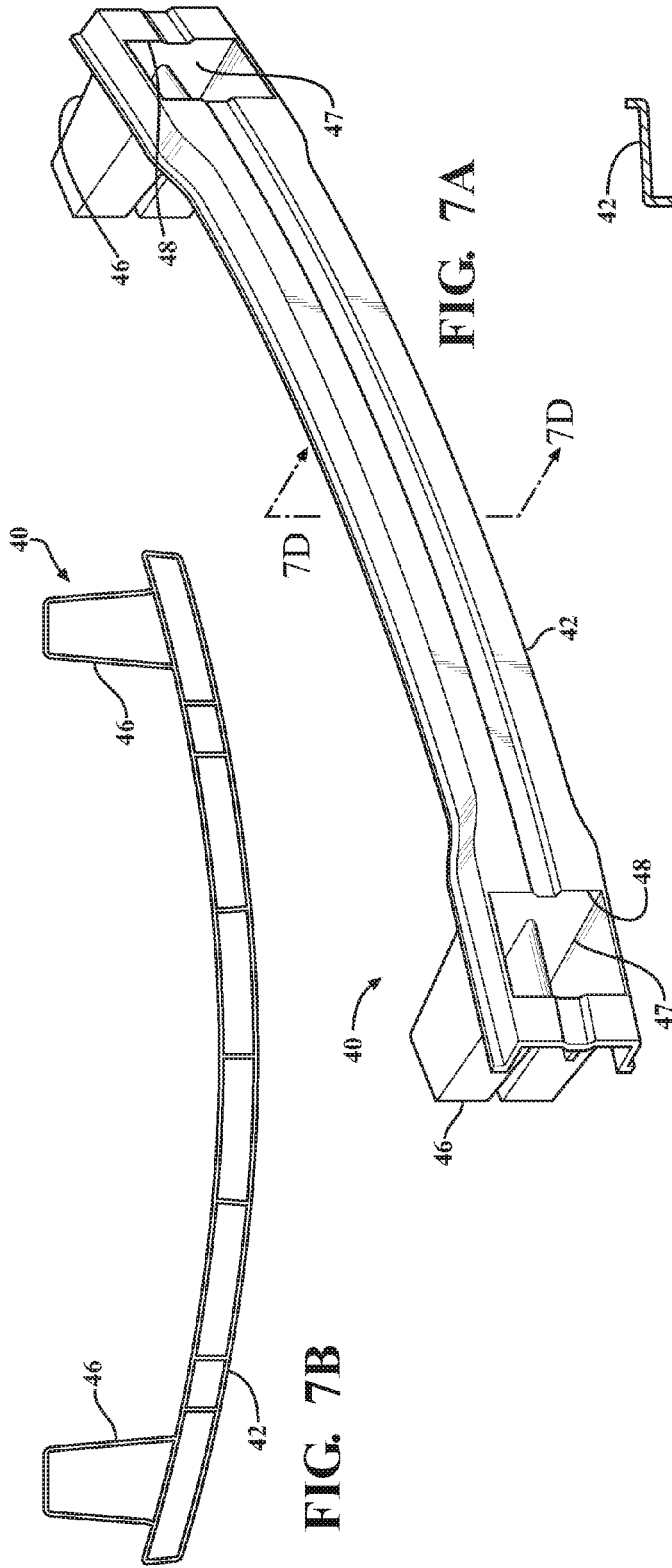


FIG. 7A

FIG. 7B

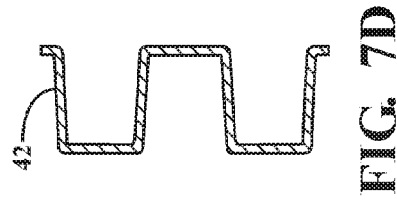


FIG. 7D

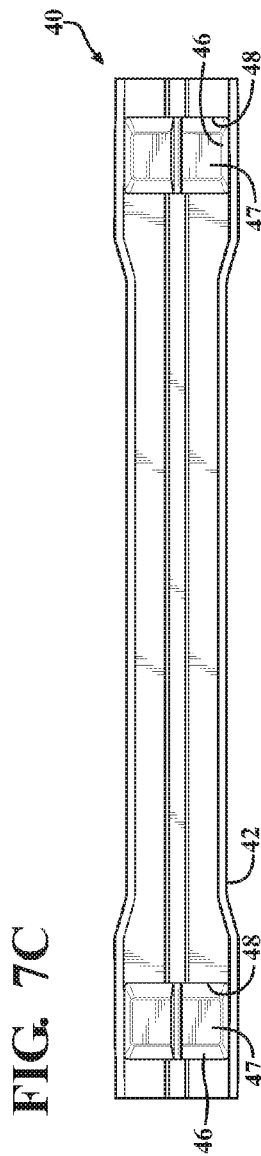


FIG. 7C

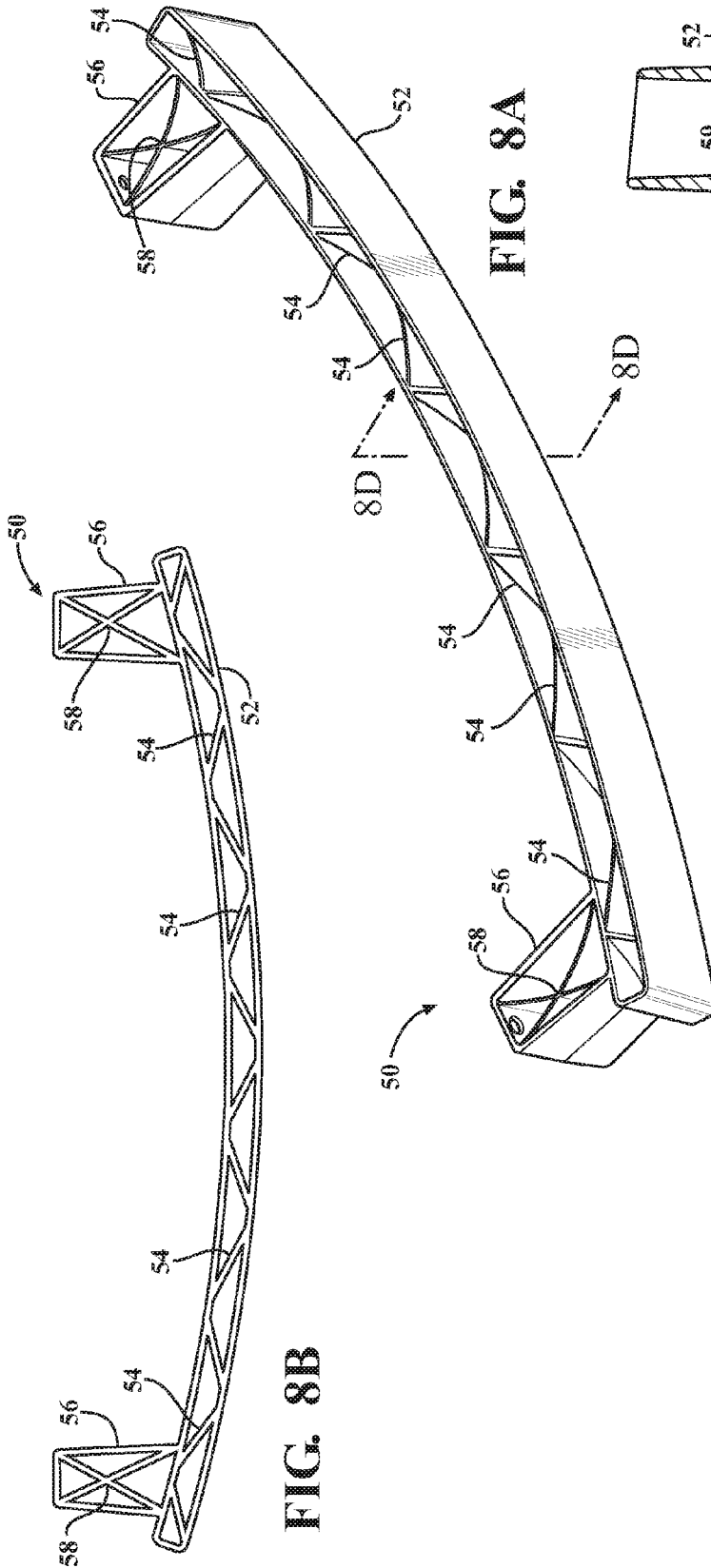


FIG. 8A

FIG. 8B

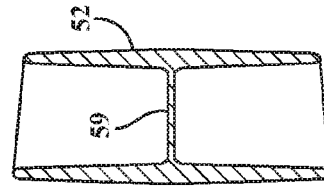


FIG. 8D

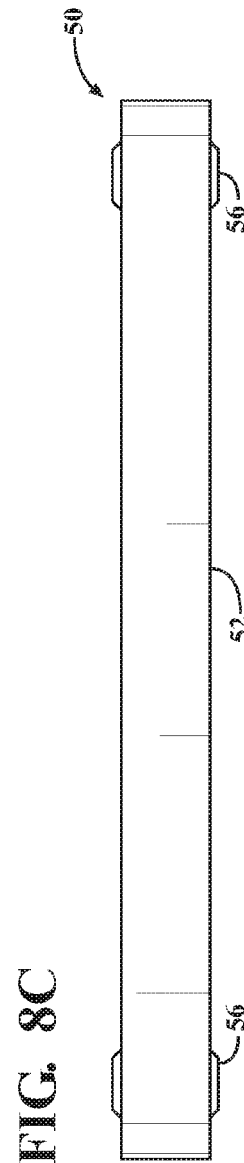
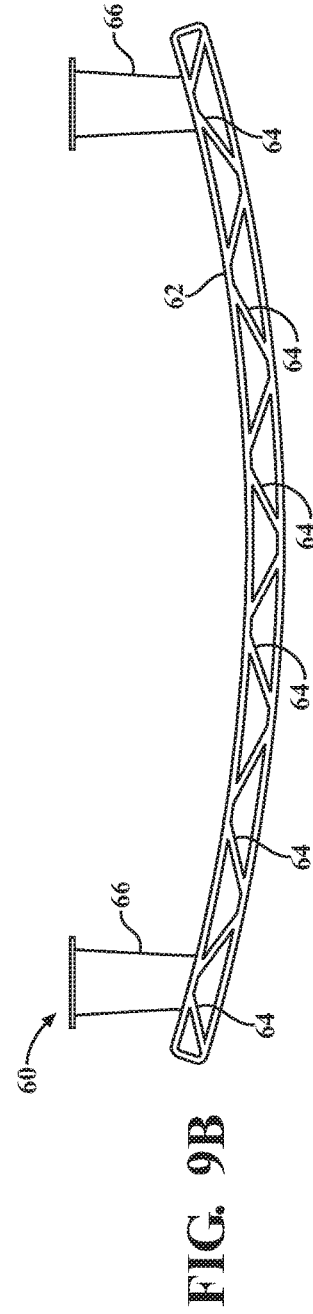
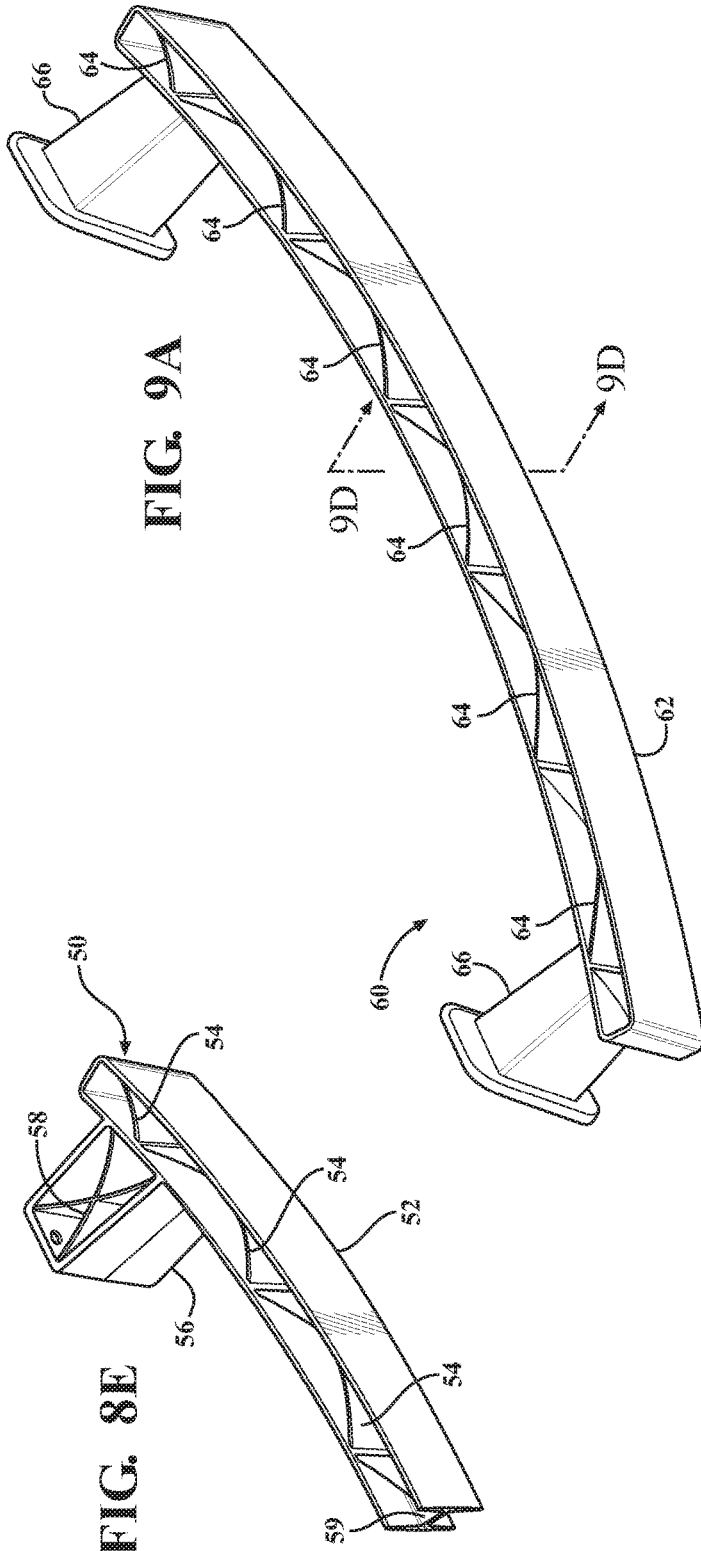


FIG. 8C



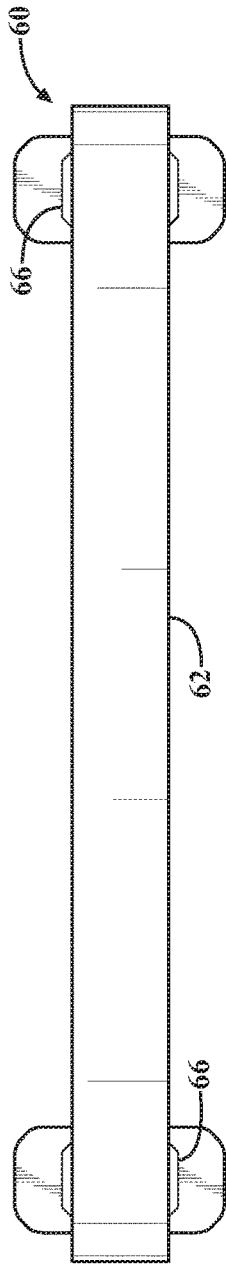


FIG. 9C

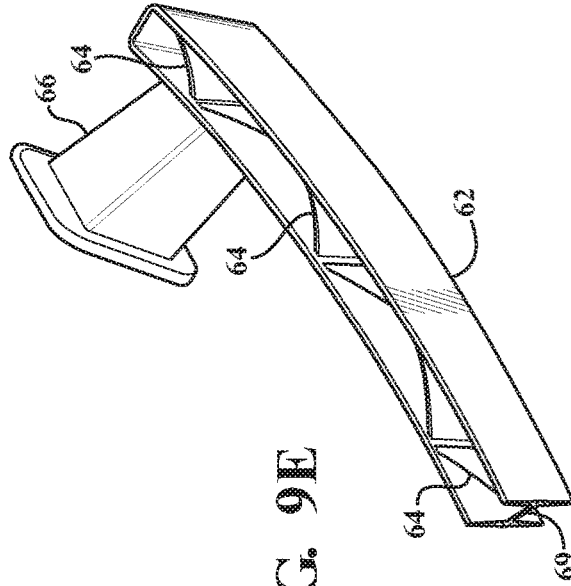


FIG. 9E

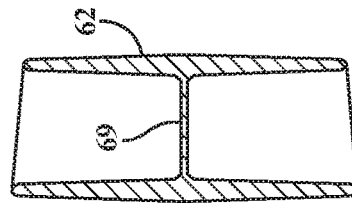


FIG. 9D

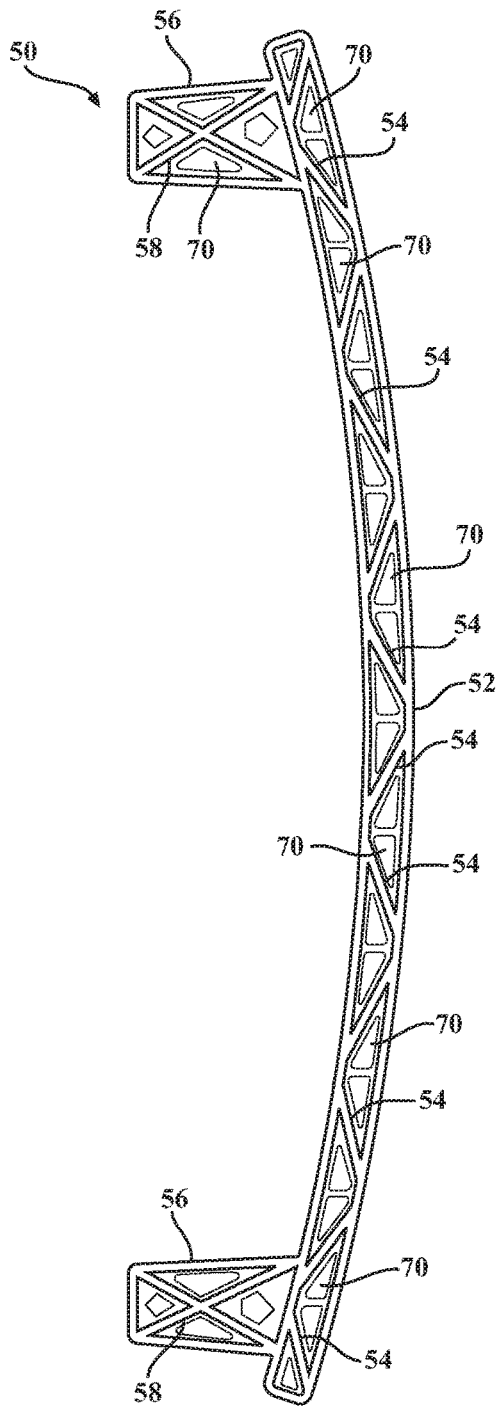


FIG. 10A

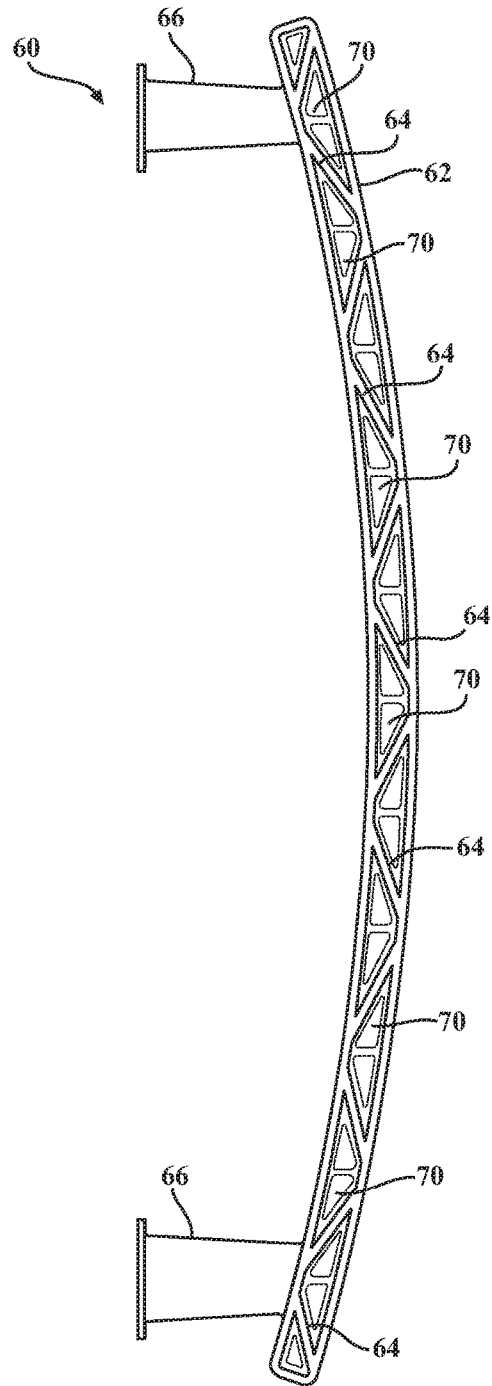


FIG. 10B

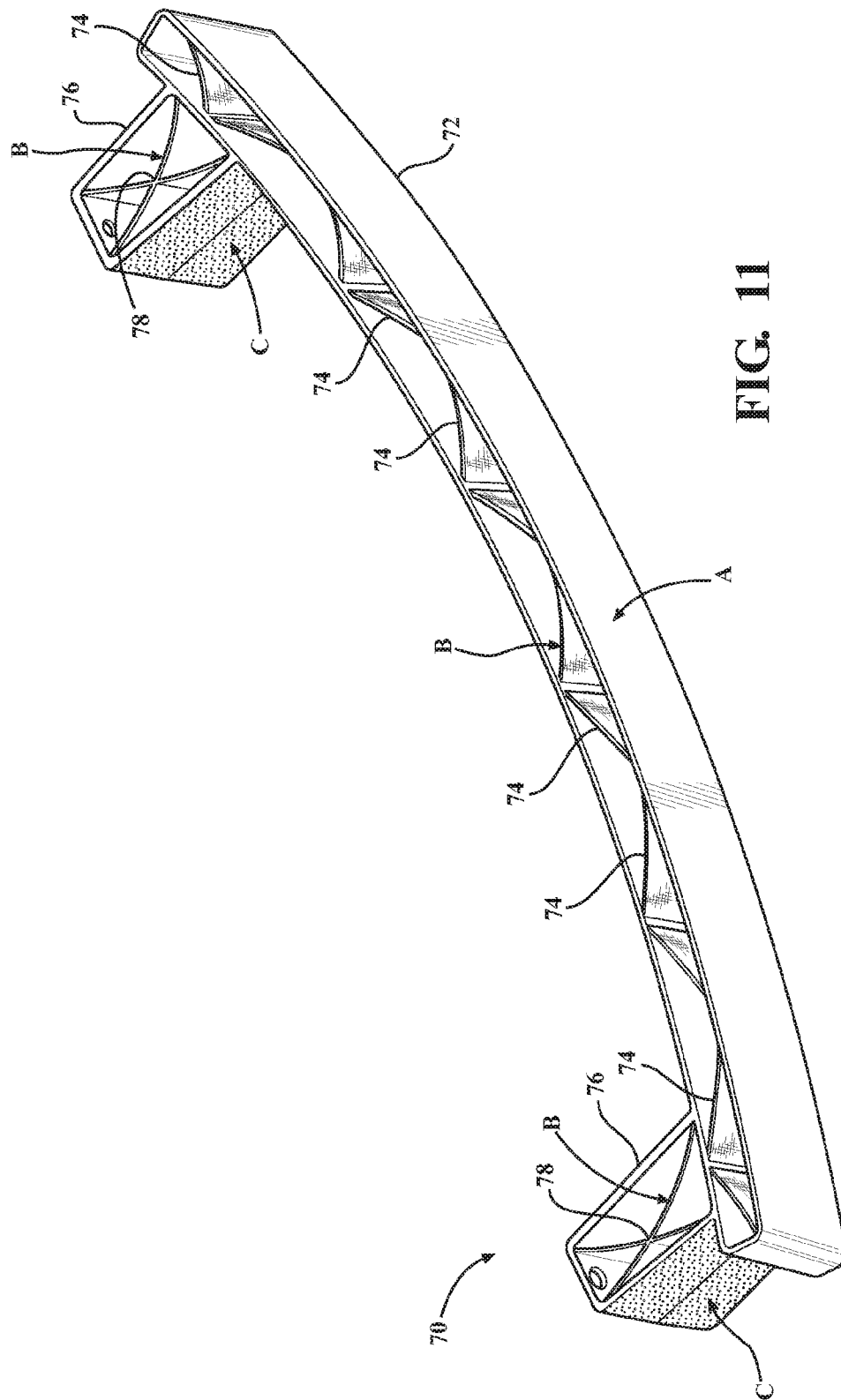


FIG. 11

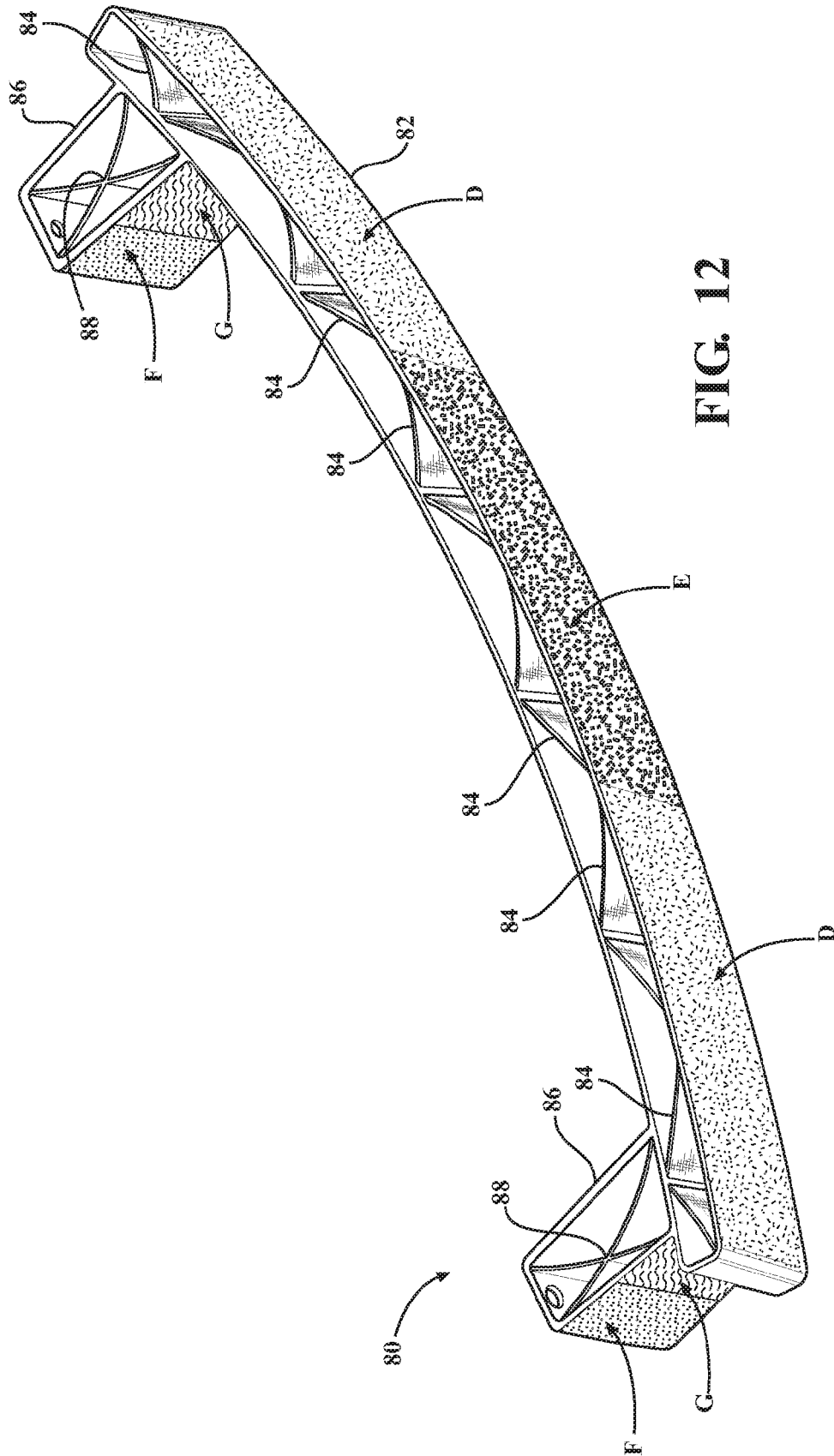


FIG. 12

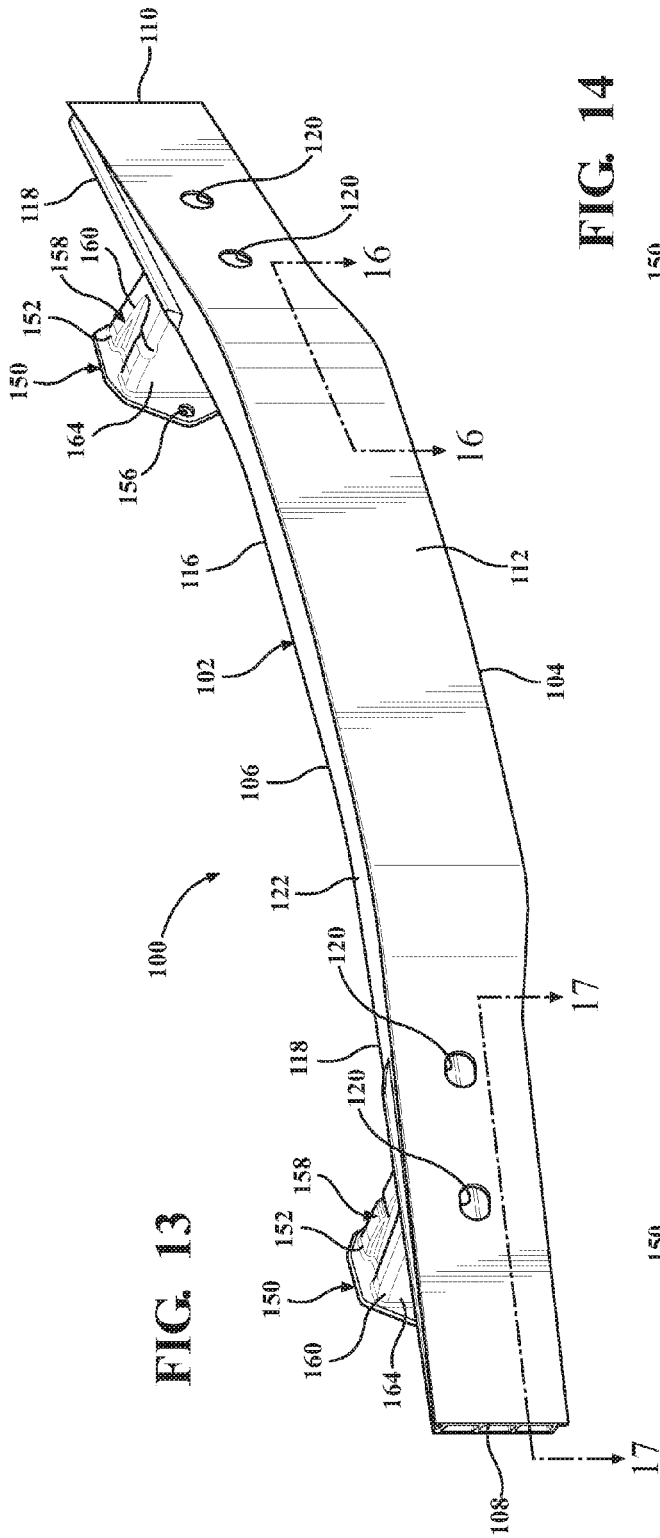
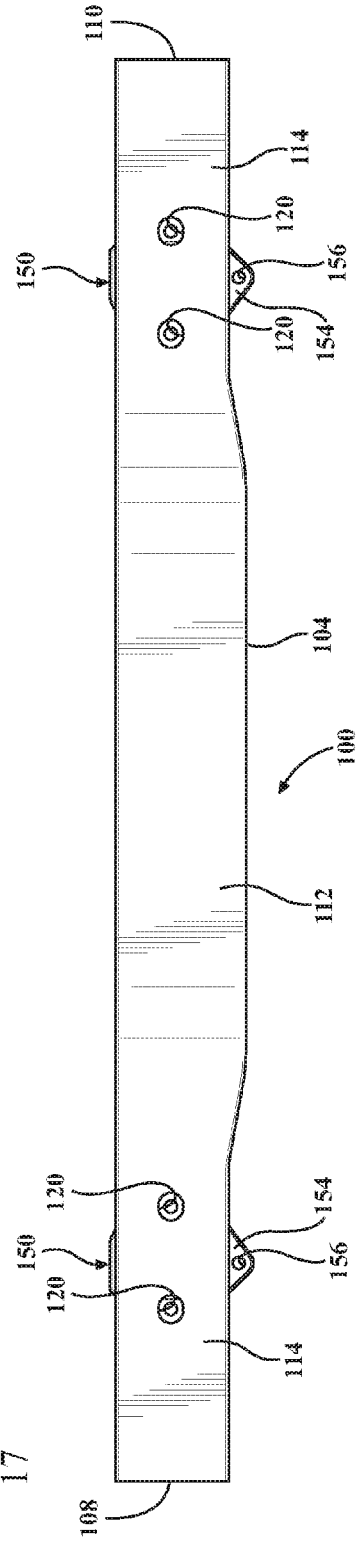


FIG. 13

FIG. 14



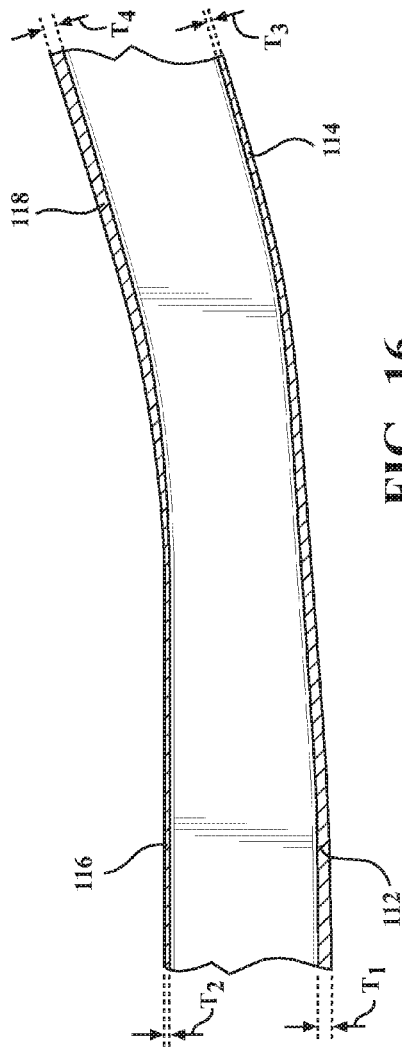


FIG. 15

FIG. 16

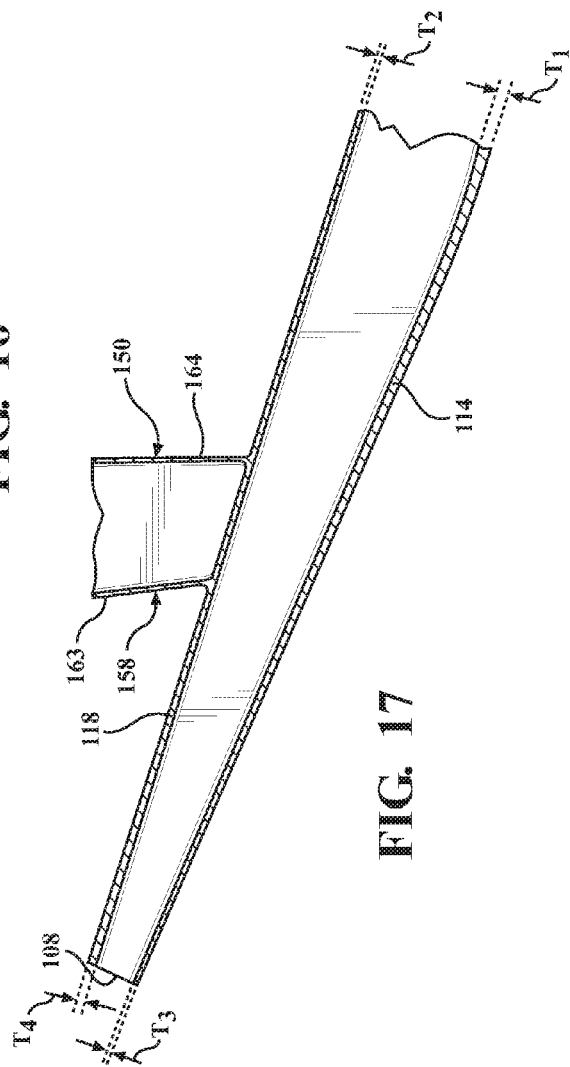
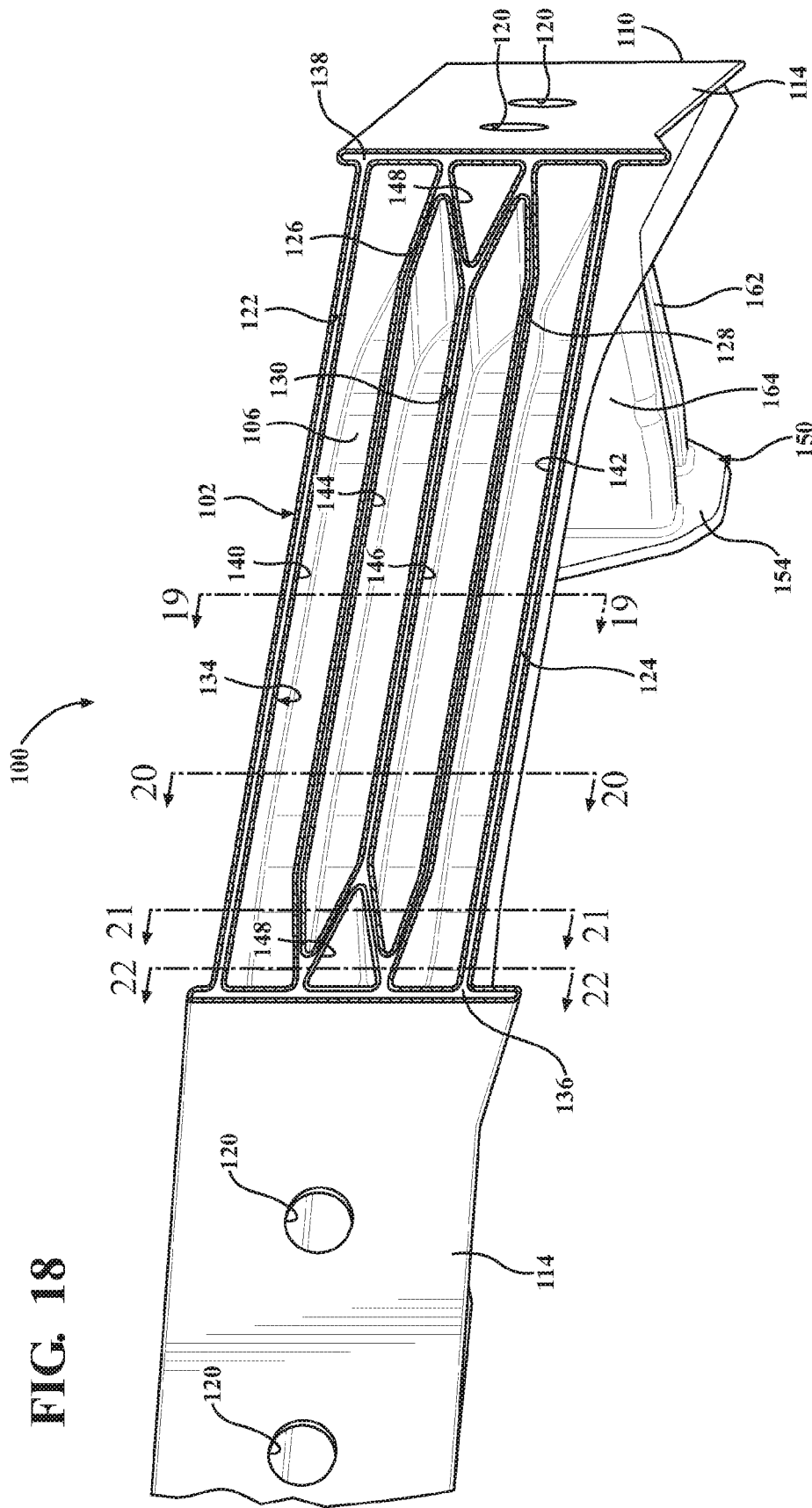


FIG. 17



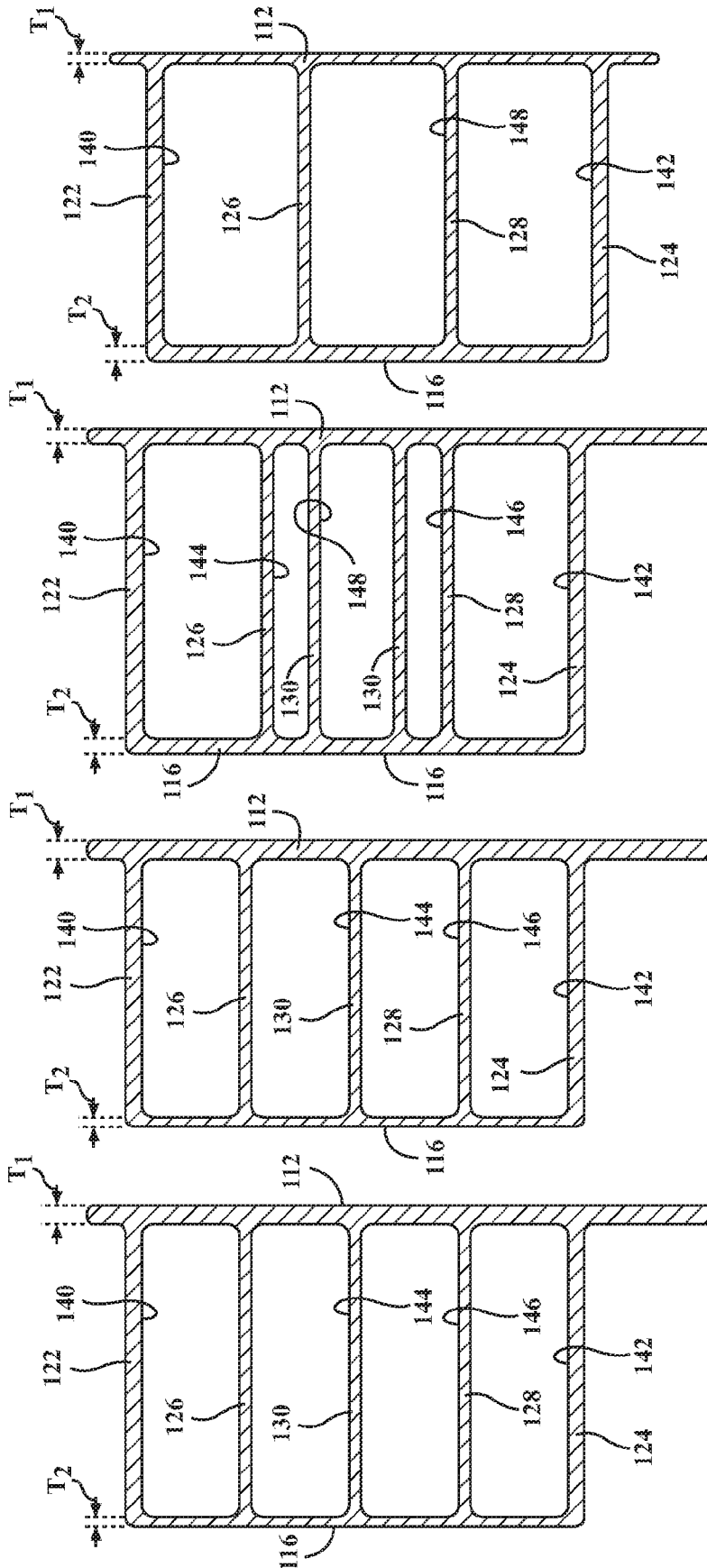


FIG. 19

FIG. 20

FIG. 21

FIG. 22

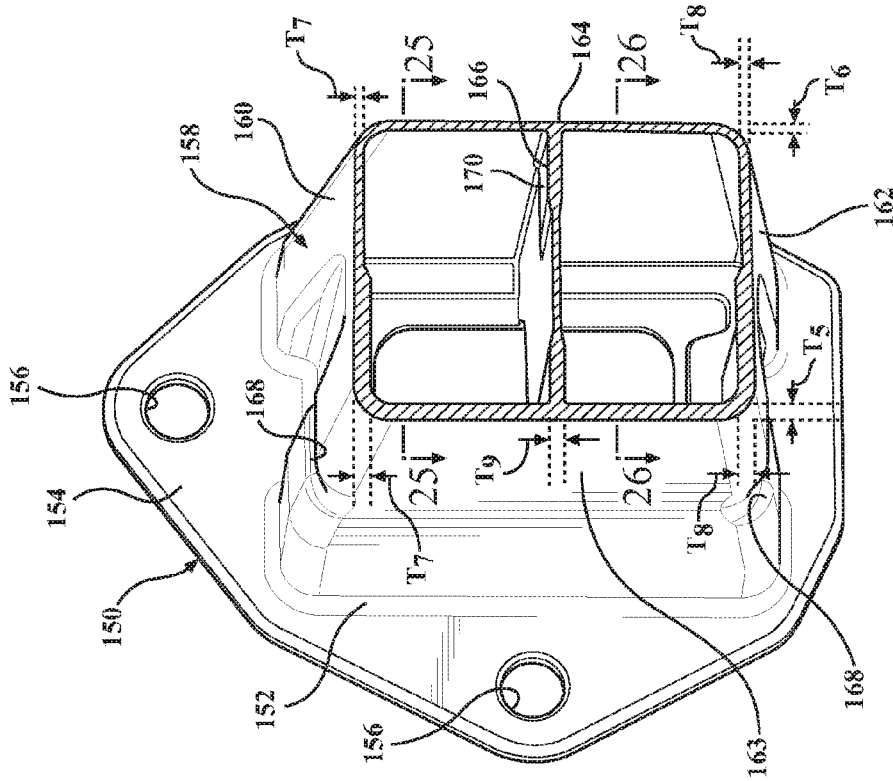


FIG. 24

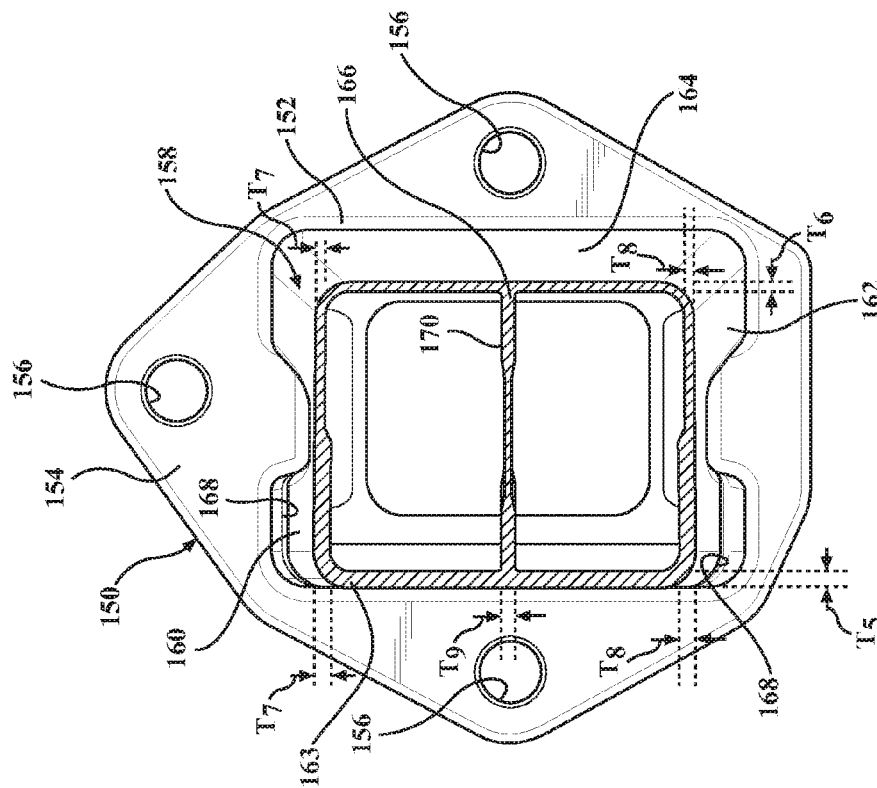


FIG. 23

FIG. 25

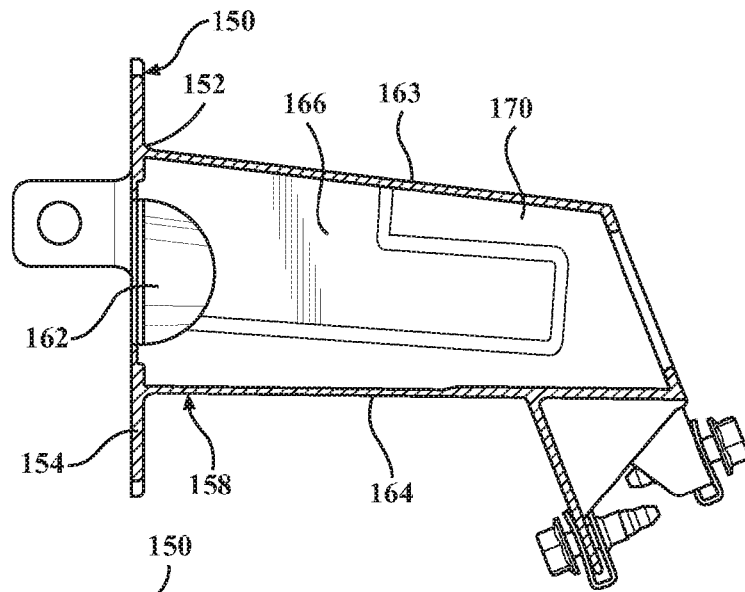


FIG. 26

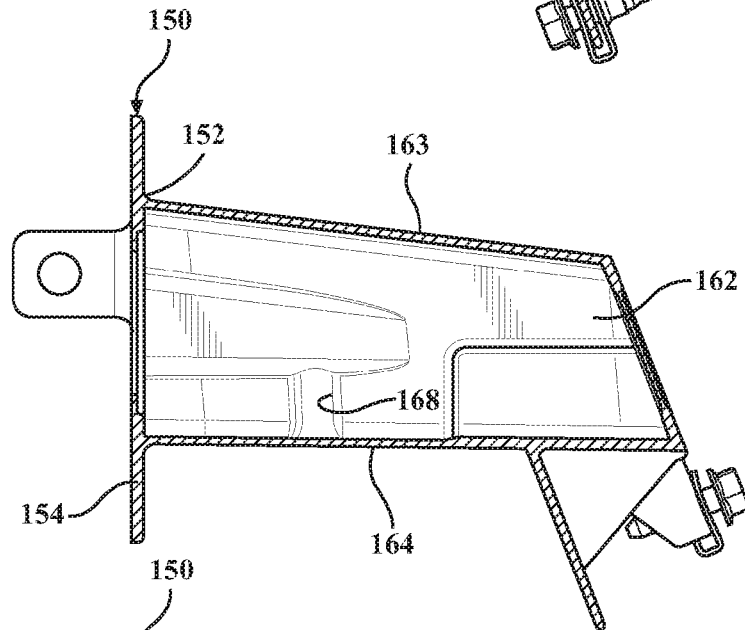


FIG. 27

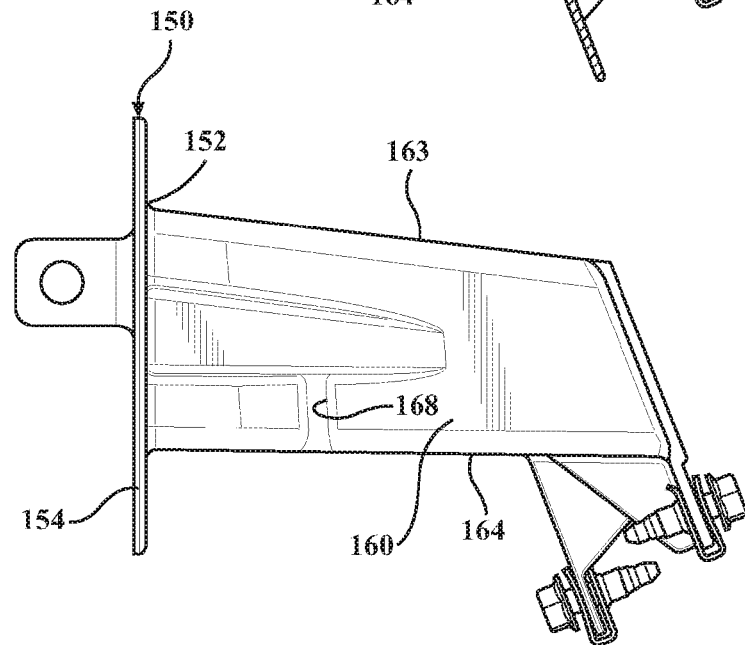


FIG. 28

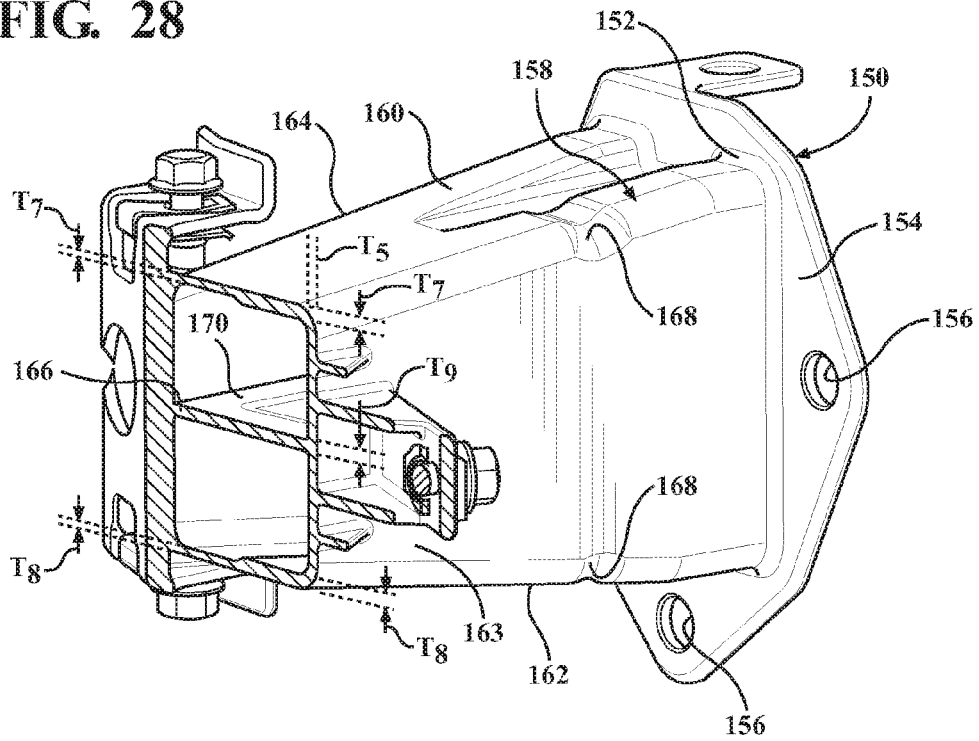
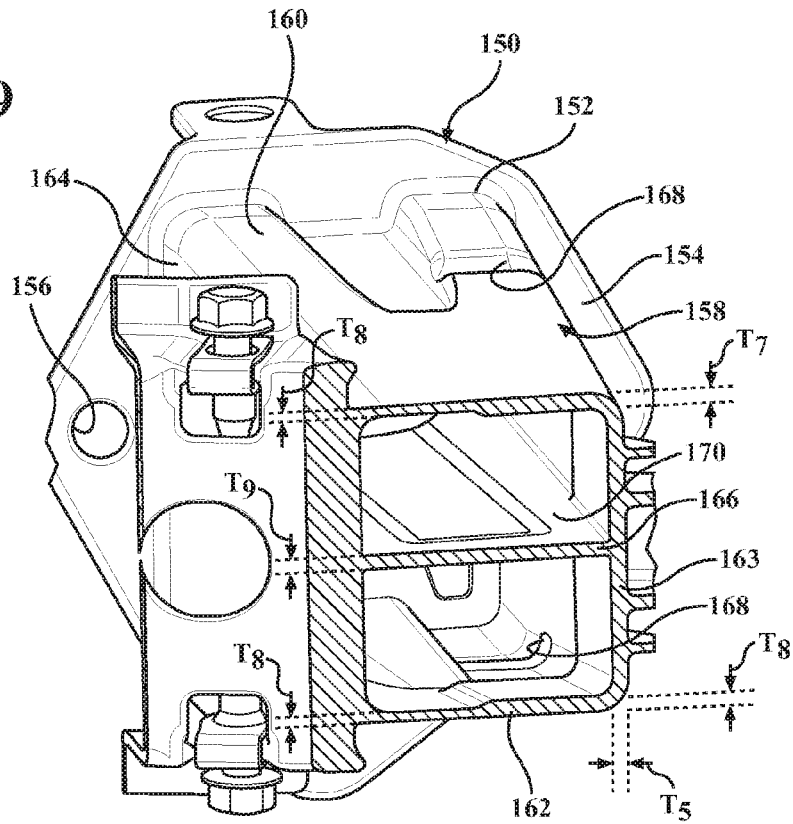


FIG. 29



CAST BUMPER SYSTEM AND METHOD OF MANUFACTURING SAME

CROSS REFERENCE TO RELATED APPLICATIONS

This patent application is a Continuation-In-Part of U.S. patent application Ser. No. 15/386,135 filed on Dec. 21, 2016 which is a Continuation-In-Part of U.S. patent application Ser. No. 15/319,878 filed on Dec. 19, 2016, which claims priority to PCT International Patent Application Serial No. PCT/US2015/039596 filed on Jul. 8, 2015, which claims the benefit of and priority to U.S. Provisional Patent Application Ser. No. 62/022,366 filed Jul. 9, 2014, the entire disclosure of these applications being considered part of the disclosure of this application, and hereby incorporated by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The subject invention is related to a vehicle bumper system including a bumper beam and a crash box. The subject invention is also related to a method of manufacturing the bumper system.

2. Description of the Prior Art

Vehicle bumper assemblies are known for providing energy absorbing characteristics. Body structures of a vehicle are provided with so-called crash boxes. Such crash boxes are disposed on the end of a frame member of a vehicle body structure so as to absorb an impact load of certain predetermined value, thereby eliminating deformation of the frame member of the vehicle body.

Bumper assemblies include a bumper beam typically extending laterally across the front or rear of a vehicle and provided generally for absorbing energy during a frontal or rear impact. Such bumper beams are disposed under a cosmetic or fascia bumper and are mounted to a vehicle frame with use of the so-called crash boxes referred to above. The crash-boxes are designed to fold upon such frontal or rear impacts.

The crash boxes are mounted to the vehicle frame and the bumper beam by many different means including, without limitation, welding, adhesives, fasteners, etc. Such crash boxes and bumper beams can be made of many different types of materials including, without limitation, steel, aluminum, and/or magnesium. In addition, such crash boxes and bumper beams are manufactured by way of extrusion, steel roll forming, or hot stamping manufacturing processes.

There remains a significant and continuing need for a design of a crash box and bumper beam that allows for lower manufacturing and assembling costs along with improved energy absorption properties. There also remains a significant and continuing need for an improved method of manufacturing a vehicle bumper system which is cost effective, reduces manufacturing steps, and also able to produce an assembled product having improved energy absorption and other performance properties.

SUMMARY OF THE INVENTION

The subject invention includes a bumper system including a bumper beam being cast from metal and having a front panel and a back panel extending in spaced relationship to

one another between a first bumper beam end and a second bumper beam end. A plurality of reinforcing ribs integrally cast with the bumper beam and extends between the front panel and the back panel for providing structural rigidity to the bumper beam. The plurality of reinforcing ribs defines a non-uniform cross-sectional profile along at least a portion of the bumper beam.

The subject invention further includes a bumper system having a bumper beam being cast from metal and having a front panel and a back panel extending in spaced relationship to one another between a first bumper beam end and a second bumper beam end. The front panel of the bumper beam includes a front center portion disposed between a pair of front side portions. The back panel of the bumper beam includes a back center portion disposed between a pair of back side portions. The front center portion has a front center portion thickness greater than a back center portion thickness of the back center portion and each of the front side portions has a front side portion thickness being less than a back side portion thickness of adjacent one of the back side portions.

The subject invention further includes a method for manufacturing a bumper system. The method includes the step of metal casting a bumper beam having a front panel and a back panel extending in spaced relationship to one another between a first bumper beam end and a second bumper beam end and a plurality of reinforcing ribs extending between the front panel and the back panel and defining a non-uniform cross-sectional profile along at least a portion of the bumper beam.

A bumper system or crash box according to the subject invention is advantageous bumper system can be manufactured with variable sections throughout its length whereby the variations can be location of walls, thickness of walls, distance between walls or even the specific number of walls. In addition, the curvature of the bumper beam would be fully variable and not linked to currently predefined manufacturing requirements. Furthermore, crush boxes would be able to fully integrate into the bumper beam as one piece component rather than multiple pieces thereby allowing for engineering optimum deformation resistance in the bumper beam and energy absorption during the crushing of the crush boxes.

BRIEF DESCRIPTION OF THE DRAWINGS

Other advantages of the present invention will be readily appreciated, as the same becomes better understood by reference to the following detailed description when considered in connection with the accompanying drawings wherein:

FIG. 1 is a perspective view of a cast bumper beam;

FIG. 2 is a top view of the cast bumper beam illustrating a plurality of reinforcement ribs integrally cast therewith;

FIG. 3 is a perspective view of a first embodiment of the bumper system illustrating the cast bumper beam secured to a crash box;

FIG. 4 is a perspective view of a second embodiment of the bumper system illustrating a cast crash box secured to a bumper beam;

FIG. 5 is a perspective view of a third embodiment of the bumper system illustrating a cast bumper beam integral with a cast crash box;

FIG. 6 is a top view of the third embodiment of the bumper system illustrating a plurality of reinforcement ribs integrally cast with the cast bumper beam;

3

FIG. 7A is a perspective view of a fourth embodiment of the bumper system including a W-shaped cast bumper beam integral with a cast crash box;

FIG. 7B is a top view of the fourth embodiment of the bumper system;

FIG. 7C is a front view of the fourth embodiment of the bumper system;

FIG. 7D is a cross-sectional view taken along A-A of FIG. 7A;

FIG. 8A is a perspective view of a fifth embodiment of the bumper system including an H-shaped cast bumper beam integral with a cast crash box and each of the cast bumper beam and cast crash box having open top and bottom surfaces;

FIG. 8B is a top view of the fifth embodiment of the bumper system;

FIG. 8C is a front view of the fifth embodiment of the bumper system;

FIG. 8D is a cross-sectional view along B-B of FIG. 8A;

FIG. 8E is a partial perspective view of the fifth embodiment of the bumper system;

FIG. 9A is a perspective view of a sixth embodiment of the bumper system including an H-shaped cast bumper beam integral with a cast crash box having closed top and bottom surfaces;

FIG. 9B is a top view of the sixth embodiment of the bumper system;

FIG. 9C is a front view of the sixth embodiment of the bumper system;

FIG. 9D is a cross-sectional view along C-C of FIG. 8A;

FIG. 9E is a partial perspective view of the sixth embodiment of the bumper system;

FIG. 10A is a top view of the bumper system shown in FIG. 8A illustrating a plurality of weight reduction holes defined by the H-shaped cast bumper beam and the cast crash box;

FIG. 10B is a top view of the bumper system shown in FIG. 9A illustrating a plurality of weight reduction holes defined by the H-shaped cast bumper beam;

FIG. 11 is a perspective view of a seventh embodiment of the bumper system wherein the bumper system is comprised of several regions or portions each comprised of a different metal alloy;

FIG. 12 is a perspective view of an eighth embodiment of the bumper system wherein a cast bumper beam is comprised of at least two regions or portions, a crash box is comprised of at least two regions or portions, and wherein each of the regions or portions are comprised of a different alloy;

FIG. 13 is a perspective view of the ninth embodiment of the bumper system wherein the bumper beam and the crash boxes are made from a casting process;

FIG. 14 is a front view of the ninth embodiment of the bumper system;

FIG. 15 is a top view of the ninth embodiment of the bumper system;

FIG. 16 is a cross-sectional of the ninth embodiment of the bumper system along the lines 16-16 in FIG. 13;

FIG. 17 is a cross-sectional of the ninth embodiment of the bumper system along the lines 17-17 in FIG. 13;

FIG. 18 is a cross-sectional perspective view of the bumper beam of the bumper system showing the plurality of reinforcing ribs;

FIG. 19 is a cross-sectional of the bumper beam along the lines 19-19 in FIG. 18;

FIG. 20 is a cross-sectional of the bumper beam along the lines 20-20 in FIG. 18;

4

FIG. 21 is a cross-sectional of the bumper beam along the lines 21-21 in FIG. 18;

FIG. 22 is a cross-sectional of the bumper beam along the lines 22-22 in FIG. 18;

FIG. 23 is a front view of the crush box of the ninth embodiment of the bumper system;

FIG. 24 is a perspective view of the crush box of the ninth embodiment of the bumper system;

FIG. 25 is a cross-sectional top view of the crush box of the ninth embodiment of the bumper system along the lines 25-25 in FIG. 24;

FIG. 26 is a cross-sectional top view of the crush box of the ninth embodiment of the bumper system along the lines 26-26 in FIG. 24;

FIG. 27 is a top view of the crush box of the ninth embodiment of the bumper system;

FIG. 28 is a perspective view of the crush box of the ninth embodiment of the bumper system; and

FIG. 29 is a perspective view of the crush box of the ninth embodiment of the bumper system.

DESCRIPTION OF THE ENABLING EMBODIMENT

Referring to the Figures, wherein like numerals indicate corresponding parts throughout the several views, FIG. 1 is a perspective view of a cast bumper beam, shown generally at 12, for use in a vehicle bumper system/assembly. Such vehicle bumper assemblies are known for providing energy absorbing characteristics, and the cast bumper beam 12 typically extends laterally across the front or rear of a vehicle (not shown) and is mounted to a vehicle frame with use of the crash boxes. The cast bumper beam 12 is cast from metal materials, such as aluminum or magnesium, and has a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system (not expressly shown). However, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Although not expressly shown, the cast bumper beam 12 can have variable, non-constant sections with regard to width, geometry, and/or thickness.

As best shown in FIG. 2, the cast bumper beam 12 can include a plurality of reinforcing ribs 14 having a "V" shape that are each cast integrally with the bumper beam 12 and arranged to facilitate controlled crash properties for the overall bumper system (not expressly shown). It should be appreciated that the "V"-shaped reinforcing ribs 14 could also be any number of other shapes depending on the design criteria selected including, without limitation, the amount of structural support desired, weight, and/or the amount of desired crush. As best shown in FIG. 3, the cast bumper beam 12 can be mounted to or combined with a crash box 16 that is manufactured according to traditional manufacturing processes, such as extrusion, steel roll forming, hot stamping, or the like, to form a first embodiment of the bumper system, generally shown at 10. In a preferred arrangement, the cast bumper beam 12 is welded to the crash box 16, however many other different means, including, without limitation, adhesives, fasteners, or the like, can also be used without departing from the scope of the subject disclosure.

FIG. 4 illustrates a second embodiment of the bumper system, shown generally at 20, in which a cast crash box 26 is be mounted to or combined with a bumper beam 22 manufactured according to traditional manufacturing processes, such as extrusion, steel roll forming, hot stamping, or

5

the like. The cast crash box **26** is cast from metal materials, such as aluminum or magnesium, and has a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system **20**. However, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Similar to the first embodiment, the cast crash box **26** can be welded to the bumper beam **22**, however many other different means, including, without limitation, adhesives, fasteners, or the like, can also be used without departing from the scope of the subject disclosure.

FIG. **5** illustrates a third embodiment of the bumper system, shown generally at **30**, which includes a cast bumper beam **32** integral with a cast crash box **36**. Put another way, in the third embodiment of the bumper system **30**, the cast bumper beam **32** and the cast crash box **36** are manufacturing integral with one another during the same casting process. Each of the cast bumper beam **32** and the cast crash box **36** are cast from metal materials, such as aluminum or magnesium, however, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Each of the cast bumper beam **32** and cast crash box **36** have a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system **30**, with one or both of these components having variable, non-constant sections with regard to width, geometry, and/or thickness.

Unlike the first and second embodiments of the bumper system **10**, **20**, the third embodiment of the bumper system advantageously does not require a weld, adhesive, or other fastener to effectuate securement of the cast crash box **36** to the cast bumper beam **32**. Accordingly, the third embodiment of the bumper system **30** reduces manufacturing steps and costs, and results in a bumper system that is stronger, cheaper, and lighter over prior art designs. In an exemplary embodiment, the bumper system **30** can be approximately **0.5 kg** lighter than prior art bumper system designs.

As best shown in FIG. **5**, the cast crash box **36** can also include a mounting plate **38** cast integral therewith for use in mounting the bumper system **30** to a vehicle frame (not expressly shown). As best shown in FIG. **6**, the cast bumper beam **32** can also include a plurality of reinforcing ribs **34** having a “V” shape that are each cast integrally with the cast bumper beam **32** and arranged to facilitate controlled crash properties for the overall bumper system (not expressly shown). It should be appreciated that the “V”-shaped reinforcing ribs **34** could also be any number of other shapes depending on the design criteria selected including, without limitation, the amount of structural support desired, weight, and/or the amount of desired crush.

FIGS. **7A-7D** illustrate a fourth embodiment of the bumper system, shown generally at **40**, which includes a cast bumper beam **42** integral with a cast crash box **46**. Similar to the third embodiment, the cast bumper beam **42** and the cast crash box **46** of the fourth embodiment of the bumper system **40** are also manufactured integral with one another during the same casting process. Each of the cast bumper beam **42** and the cast crash box **46** are cast from metal materials, such as aluminum or magnesium, however, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Each of the cast bumper beam **42** and cast crash box **46** have a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system **40**, with one or both of these components having variable, non-constant sections with regard to width, geometry, and/or thickness. The fourth embodiment of the

6

bumper system also advantageously does not require a weld, adhesive, or other fastener to effectuate securement of the cast crash box **46** to the cast bumper beam **42**. Accordingly, the fourth embodiment of the bumper system **30** reduces manufacturing steps and costs, and results in a bumper system that is stronger, cheaper, and lighter over prior art designs.

As best shown in FIG. **7A**, each of the cast crash boxes **46** define an internal cavity **47** and the cast bumper beam **42** defines a plurality of front openings **44** each disposed adjacent to and in communication with a respective internal cavity **47** of the cast crash boxes **46**. The incorporation of the front openings **44** into the cast bumper beam **42** improves the manufacturability of the cast bumper system **40**. As best shown in FIG. **7D**, the cast bumper beam can also be cast to have a “W” shape extending along at least a portion of its length to facilitate controlled crash properties for the bumper system **40**.

FIGS. **8A-8E** illustrate a fifth embodiment of the bumper system, shown generally at **50**, which includes a cast bumper beam **52** integral with a cast crash box **56**. Put another way, similar to the third and fourth embodiments, the cast bumper beam **52** and the cast crash box **56** of the fifth embodiment of the bumper system **50** are also manufactured integral with one another during the same casting process. Each of the cast bumper beam **52** and the cast crash box **56** are cast from metal materials, such as aluminum or magnesium, however, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Each of the cast bumper beam **52** and the cast crash box **56** have a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system **50**, with one or both of these components having variable, non-constant sections with regard to width, geometry, and/or thickness. The fifth embodiment of the bumper system **50** also advantageously does not require a weld, adhesive, or other fastener to effectuate securement of the cast crash box **56** to the cast bumper beam **52**. Accordingly, the fifth embodiment of the bumper system **50** reduces manufacturing steps and costs, and results in a bumper system that is stronger, cheaper, and lighter over prior art designs.

As best shown in FIGS. **8A** and **8D-8E**, each of the cast bumper beam **52** and cast crash boxes **56** are open along a top and bottom portion to improve the manufacturability of the cast bumper system **50**. As best shown in FIGS. **8A-8B** and **8E**, the cast bumper beam **52** can include a plurality of reinforcing ribs **54** having a “V” shape that are each cast integrally with the bumper beam **52** and the cast crash boxes **56** can include a plurality of reinforcing ribs **58** having an “X” shape that are each cast integrally with the crash box **56**. The reinforcing ribs **54**, **58** are arranged to facilitate controlled crash properties for the bumper system **50**. It should be appreciated that the “V”-shaped and “X”-shaped reinforcing ribs **54**, **58** could also be any number of other shapes depending on the design criteria selected including, without limitation, the amount of structural support desired, weight, and/or the amount of desired crush. As best shown in FIGS. **8D** and **8E**, the cast bumper beam **52** can also be cast to have an “H” shape and define an additional horizontal or transverse rib **59** extending along at least a portion of the length to further control the crash properties of the bumper system **50**.

FIGS. **9A-9E** illustrate a sixth embodiment of the bumper system, shown generally at **60**, which includes a cast bumper beam **62** integral with a cast crash box **66**. Similar to the third, fourth, and fifth embodiments, the cast bumper beam

62 and the cast crash box 66 of the sixth embodiment of the bumper system 60 are manufactured integral with one another during the same casting process. Each of the cast bumper beam 62 and the cast crash box 66 are cast from metal materials, such as aluminum or magnesium, however, other types of metal and/or metal alloys may be selected without departing from the scope of the subject disclosure. Each of the cast bumper beam 62 and cast crash box 66 have a specific design of geometry that can be tuned to meet the energy absorbance and weight requirements for the overall bumper system 60, with one or both of these components having variable, non-constant sections with regard to width, geometry, and/or thickness. The sixth embodiment of the bumper system 60 also advantageously does not require a weld, adhesive, or other fastener to effectuate securement or mounting of the cast crash box 66 to the cast bumper beam 62. Accordingly, the sixth embodiment of the bumper system 60 reduces manufacturing steps and costs, and results in a bumper system that is stronger, cheaper, and lighter over prior art designs.

As best shown in FIGS. 9A-9B and 9E, the cast bumper beam 62 is open along a top and bottom portion of the bumper system 60, while the cast crash box 66 is closed along these same portions. As best shown in FIGS. 9A-9B and 9E, the cast bumper beam 62 can include a plurality of reinforcing ribs 64 having a "V" shape that are each cast integrally with the cast bumper beam 62. However, it should be appreciated that the "V"-shaped reinforcing ribs 64 could also be any number of other shapes depending on the design criteria selected including, without limitation, the amount of structural support desired, weight, and/or the amount of desired crush. As best shown in FIGS. 9D and 9E, similar to the fifth embodiment, the cast bumper beam 62 can also be cast to have an "H" shape and define an additional horizontal or transverse rib 69 extending along at least a portion of the length to further control the crash properties of the bumper system 60.

FIGS. 10A and 10B illustrate an alternative arrangement of the fifth and sixth embodiments of the bumper system 50, 60, respectively, in which the horizontal or transverse rib 59, 69 of the bumper beam 52, 62 defines a plurality of weight reduction holes 70 to further reduce the overall weight of the cast bumper system 50, 60. As shown in FIG. 10A, in the alternative arrangement of the fifth embodiment of the bumper system, the cast crash box 56 can also define a plurality of weight reduction holes to even further reduce the overall weight of the cast bumper system 50.

According to an aspect of the subject disclosure, any of the aforementioned embodiments of the subject bumper system may be manufactured such that they are comprised of multiple grades of alloys at various regions or portions of the metal cast bumper system to allow the bumper system to be efficiently tuned to meet certain vehicle performance requirements. More specifically, as illustrated in FIGS. 11 and 12, the bumper system 70, 80 may be divided into a plurality of regions or portions A, B, C, D, E, F, G with at least two of the regions or portions A, B, C, D, E, F, G comprised of different alloys than one another such that each region or portion A, B, C, D, E, F, G may be specialized and tuned for predetermined performance and mass characteristics.

In the embodiment of FIG. 11, a metal cast bumper beam 72 makes up the first region A, a plurality of cast reinforcing ribs 74, 78 of the metal cast bumper beam 72 or metal cast crash boxes 76 make up the second region B, and a part of the metal cast crash boxes 76 makes up the third region C. In this example, an alloy that has excellent crush and energy

absorbing characteristics can be selected for the second region B (the reinforcing ribs 74, 78), or other parts of the system that will be crushed on impact. Additionally, an alloy that has higher strength can be selected for the first region A (the bumper beam 72), or other parts of the bumper system 70 that are intended to transfer energy instead of absorb energy. As such, FIG. 11 demonstrates that different components of the metal cast bumper system 70 can be comprised of different alloys than one another. It should be appreciated that in this and the other embodiments of the subject invention, the cast bumper beam 72 and crash box 76 may either be integrally connected or non-integrally connected, e.g., mechanically connected, to one another.

Furthermore, individual components of the metal cast bumper system can be comprised of more than one region or portion of different alloys. For example, as illustrated in FIG. 12, the cast bumper beam 82 includes a first bumper beam portion E at a central region of the cast bumper beam 82 and which is comprised of a first bumper beam alloy. The cast bumper beam 82 also includes a second bumper beam portion D that is located at the outer regions of the bumper beam 82 on opposing sides of the central region E, and which is comprised of a second bumper beam alloy. The first and second bumper beam alloys are different than one another to refine and tune the performance characteristics of the metal cast bumper system 80. Furthermore, a pair of cast crash boxes 86 each include a first crash box region F that is located at a rearward region of the crash box 86 and comprised of a first crash box alloy. The pair of cast crash boxes 86 each also include a second crash box region G that is located at a forward region of the crash box 86 between the rearward region F and the bumper beam 82 and comprised of second crash box alloy. The first and second crash box alloys are different than one another as well as the first and second bumper beam alloys to refine and tune the performance characteristics of the metal cast crash boxes 86. As such, the metal cast crash boxes 86 are configured to have different performance characteristics across their lengths.

According to another aspect of the present disclosure, the bumper system 100, as generally shown in FIG. 13, includes a bumper beam 102 with the bumper beam 102 being cast from metal. The bumper beam 102 has a front panel 104 and a back panel 106. The front panel 104 and the back panel 106 extends between a first bumper beam end 108 and a second bumper beam end 110 in a spaced relationship to one another. The front panel 104 and the back panel 106 may be of any shape such as, but not limited to, a rectangular shape. It should be appreciated that a secondary bracket may be attached at the first bumper beam end 108 and the second bumper beam end 110 for the management of narrow offset impact energy.

The front panel 104 of the bumper beam 102 includes a front center portion 112 disposed between a pair of front side portions 114. In other words, the front side portions 114 extend outwardly from the front center portion 112. It should be appreciated that the front side portions 114 may extend outwardly from the front center portion 112 at a first angle of greater than 90° relative to the front center portion 112. The back panel 106 of the bumper beam 102 includes a back center portion 116 disposed between a pair of back side portions 118. In other words, the back side portions 118 extend outwardly from the back center portion 116. It should be appreciated that the back side portions 118 may extend outwardly from the back center portion 116 at a second angle of greater than 90° relative to the back center portions 116 wherein the second angle can be greater than the first angle. As best shown in FIG. 14, each of the front side portions 114

defines a pair of apertures **120**, each having a circular shape and spaced from one another, for receiving and securing a vehicle bumper to the bumper beam **102**. The front center portion **112** and the front side portions **114** may have a constant shape, e.g., rectangular shape, or a non-constant shape, e.g., rectangular shapes that are different in size.

As best shown in FIG. **18**, the bumper beam **102** includes a plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** integrally cast with the bumper beam **102** and extends between the front panel **104** and the back panel **106** for providing structural rigidity to the bumper beam **102**. The plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** defines a non-uniform cross-sectional profile **134** along at least a portion of the bumper beam **102**. As the plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** extends longitudinally between a first profile end **136** disposed relative to the first bumper beam end **108** and a second profile end **138** disposed relative to the second bumper beam end **110**, the plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** defines a plurality of pockets **140**, **142**, **144**, **146**, **148** varying in quantity to establish the non-uniform cross-section profile.

The plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** includes a top reinforcing rib **122** and a bottom reinforcing rib **124** disposed in spaced relationship to one another and extending longitudinally and linearly between the first profile end **136** and the second profile end **138**. The plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** further includes at least one intermediate rib **126**, **128**, **130** disposed between the top reinforcing rib **122** and the bottom reinforcing rib **124** and extending longitudinally and non-linearly between the first profile end **136** and the second profile end **138** to define the non-uniform cross-sectional profile **134** taken along a plane disposed perpendicular to the plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** and extending between the first profile end **136** and the second profile end **138**.

The at least one intermediate rib **126**, **128**, **130** includes a plurality of intermediate reinforcing ribs **126**, **128**, **130** disposed between the top reinforcing rib **122** and the bottom reinforcing rib **124**. Each one of the plurality of intermediate reinforcing ribs **126**, **128**, **130** extends longitudinally and non-linearly between the first profile end **136** and the second profile end **138**. Adjacent intermediate reinforcing ribs **126**, **128**, **130** of the plurality of intermediate reinforcing ribs **126**, **128**, **130** converge with one another at the first profile end **136** and the second profile end **138** to define the non-uniform cross-section. The plurality of intermediate reinforcing ribs **126**, **128**, **130** includes a first intermediate reinforcing rib **126** disposed adjacent the top reinforcing rib **122**, a second intermediate reinforcing rib **128** disposed adjacent the bottom reinforcing rib **124**, and a third intermediate reinforcing rib **130** disposed between the first intermediate reinforcing rib **126** and the second intermediate reinforcing rib **128**. As best shown in FIGS. **18-22**, the plurality of pockets **140**, **142**, **144**, **146**, **148** includes a first pocket **140**, having a generally rectangular cross-sectional shape, disposed between the top reinforcing rib **122** and the first intermediate reinforcing rib **126**; a second pocket **142**, having a rectangular cross-sectional shape, disposed between the second intermediate reinforcing rib **128** and the bottom reinforcing rib **124**; a third pocket **144**, having an elongated hexagonal cross-sectional shape, disposed between the first intermediate reinforcing rib **126** and the third intermediate reinforcing rib **130**; a fourth pocket **146**, having an elongated hexagonal cross-sectional shape, disposed between the third intermediate reinforcing rib **130** and the second intermediate reinforcing rib **128**; and a pair of fifth pockets **148**, having a

triangular cross-sectional shape, each disposed adjacent respective the first profile end **136** and the second profile end **138** and between the converging portions **112**, **114**, **116**, **118** of the intermediate reinforcing ribs **126**, **128**, **130**.

As best illustrated in FIGS. **15-18**, the front center portion **112** of the front panel **104** has a front center portion thickness T_1 . The back center portion **116** of the back panel **106** has a back center portion thickness T_2 wherein the front center portion thickness T_1 is greater than the back center portion thickness T_2 of the back center portion **116**. Each of the front side portions **114** has a front side portion thickness T_3 and each of the back side portions **118** has a back side portion thickness T_4 wherein the front side portion thickness T_3 is less than the back side portion thickness T_4 of the back side portions **118**. The front center portion thickness T_1 is greater than the front side portion thickness T_3 and the back center portion thickness T_2 being less than the back side portion thickness T_4 . In other words, at the center of the bumper beam **102**, the front panel **104** is thick while the back panel **106** is thin. Because the center of the bumper must resist buckling during several testing events, an increase in the front panel **104** thickness, e.g., front center portion thickness T_1 , is a very effective method of increasing local buckling performance. The rear side of the bumper beam **102**, e.g., the back side portions **118**, is in tension in the same test case and, therefore, local resistance is not required. On the other hand, near the first bumper beam end **108** and the second bumper beam end **110**, the front panel **104** is thin and the back panel **106** is thick. Near the first bumper beam end **108** and the second bumper beam end **110**, the front side portions **114** is not at risk of buckling and primarily react with the foam force. The back side portions **118** must effectively transfer the load to the crush cans and an increase in back panel **106** thickness, e.g., back side portion thickness T_4 , is beneficial for transferring the load to the crush cans.

As best shown in FIGS. **15** and **17**, the bumper beam **102** includes a pair of crush boxes **150** integrally cast with and extending outwardly from the back panel **106**. In other words, the crush boxes **150** and the bumper beam **102** is a monolithic structure. Each of the crush boxes **150** extends outwardly from the back panel **106** to an attachment end **152** and tapering from the attachment end **152** to the back panel **106**. Each of the crush boxes **150** includes a mounting plate **154**, having a rectangular shape and integrally cast with the crush boxes **150**. The mounting plate **154** extends outwardly from the attachment end **152** and defines a plurality of mounting holes **156** spaced from one another for securing the crush box **150** and the bumper beam **102** to a vehicle frame.

As shown in FIGS. **23-24**, each of the crush boxes **150** has a body **158** including a top wall **160**, a bottom wall **162**, and a pair of side walls **163**, **164** extending between the top wall **160** and the bottom wall **162**. The side walls **163**, **164** include a first side wall **163** having a first side wall thickness T_5 and a second side wall **164** having a second side wall thickness T_6 and with the first side wall thickness T_5 being greater than the second side wall thickness T_6 . As best shown in FIGS. **28** and **29**, the top wall **160** has a variable top wall thickness T_7 between the first side wall **163** and second side wall **164**. The bottom wall **162** has a variable bottom wall thickness T_8 between the first side wall **163** and second side wall **164**. The variable top wall thickness T_7 is equal to the first side wall thickness T_5 adjacent the first side wall **163** and decreases to be equal to the second side wall thickness T_6 adjacent the second side wall **164**. The variable bottom wall thickness T_8 is equal to the first side wall

thickness T_5 adjacent the first side wall **163** and decreases to be equal to the second side wall thickness T_6 adjacent the second side wall **164**.

Each of the crush boxes **150** further includes a reinforcing plate **166** integrally cast and extends in spaced relationship with the top wall **160** and the bottom wall **162** and between the pair of side walls **163**, **164**. The reinforcing plate **166** has a variable reinforcing plate thickness T_9 between the pair of side walls **163**, **164**. The reinforcing plate **166** includes at least one internal reinforcing rib **170** to define the variable reinforcing plate thickness T_9 . The top wall **160** and the bottom wall **162** each define at least one buckle initiating grooves **168** integrally cast with the top wall **160** and the bottom wall **162** for allowing the crush boxes **150** to buckle and deform in response to a buckling force applied to the bumper beam **102**.

It is another aspect of the present disclosure to provide a method for manufacturing a bumper system **100**. The method includes the step of metal casting a bumper beam **102** having a front panel **104** and a back panel **106** extending in spaced relationship to one another between a first bumper beam end **108** and a second bumper beam end **110** and a plurality of reinforcing ribs **122**, **124**, **126**, **128**, **130** extending between the front panel **104** and the back panel **106** and defining a non-uniform cross-sectional profile **134** along at least a portion of the bumper beam **102**. The step of metal casting includes a step of forming the front panel **104** including a front center portion **112** disposed between a pair of front side portions **114** and the back panel **106** including a back center portion **116** disposed between a pair of back side portions **118** with the front center portion **112** having a front center portion thickness T_1 being greater than a back center portion thickness T_2 of the back center portion **116**, and each of the front side portions **114** having a front side portion thickness T_3 being less than a back side portion thickness T_4 of adjacent one of the back side portions **118**. The step of metal casting also includes a step of forming a pair of crush boxes **150** integrally cast with and extending outwardly from the back side portions **118** of the back panel **106**, each of the crush boxes **150** having a body **158** including a top wall **160** and a bottom wall **162** and a pair of side walls **163**, **164** extending between the top wall **160** and the bottom wall **162**, and a reinforcing plate **166** disposed in the crush box **150** in spaced relationship between the top wall **160** and the bottom wall **162** and extending between the pair of side walls **163**, **164** connecting the side walls **163**, **164** with one another. The step of metal casting further includes a step of forming at least one buckle initiating groove **168** on the top wall **160** and the bottom wall **162** of the crush box **150**. The step of metal casting further includes forming at least one internal reinforcing rib **172** on the walls **160**, **162**, **163**, **164** and the reinforcing plate **166** of the crush box **150**.

It should be appreciated that various other components and/or combinations of components can comprise regions or portions of different alloys and more than two different regions or portions can extend along the metal cast bumper beam. It should also be appreciated that various alloys may be utilized including, but not limited to, aluminum-based, e.g., 5000, 6000, or 7000 series aluminum alloys, magnesium-based, and iron-based alloys.

Although not expressly shown in the Figures, one or both of the bumper beam or the crash box in any of the aforementioned embodiments of the bumper system can also be cast to incorporate various design features including but not limited to: head lamps, ambient air sensors, pedestrian brackets, collision avoidance sensors, a hood latch, pedes-

trian protection systems, horns, grilles, fog lamps, toe hooks, threaded inserts, and neoprene shock absorption materials. As such, the cast bumper system can incorporate design features and shapes that would otherwise have to be welded onto prior art bumper assemblies, or stretch bent into prior art bumper assemblies. Thus, the cast bumper system avoids the machining and welding operations that are required to incorporate these features into prior art bumper assemblies manufactured by way of extrusion, steel roll forming, hot stamping, or the like.

Although not expressly shown in the figures, the cast bumper beam in any of the aforementioned embodiments of the bumper system can also be cast to have a "U"-shape or "C"-shape extending along a portion of its length.

Although not expressly shown in the Figures, one or both of the bumper beam or the crash box in any of the aforementioned embodiments of the bumper system can also include absorption inserts placed anywhere within or along the bumper system.

The foregoing invention has been described in accordance with the relevant legal standards, thus the description is exemplary rather than limiting in nature. Variations and modifications to the disclosed embodiment may become apparent to those skilled in the art and fall within the scope of the invention.

What is claimed is:

1. A bumper system comprising:

a bumper beam being cast from metal and having a front panel and a back panel extending in spaced relationship to one another between a first bumper beam end and a second bumper beam end,

a plurality of reinforcing ribs integrally cast with said bumper beam and extending between said front panel and said back panel for providing structural rigidity to said bumper beam, and

said plurality of reinforcing ribs including a top reinforcing rib and a bottom reinforcing rib disposed in spaced relationship to one another and extending longitudinally and linearly between a first profile end disposed relative to said first bumper beam end and a second profile end disposed relative to said second bumper beam end and at least one intermediate rib disposed between said top and bottom reinforcing rib and extending longitudinally and non-linearly between said first and second profile ends to define a non-uniform cross-sectional profile of said bumper beam taken along a plane disposed perpendicular to said plurality of reinforcing ribs and extending between said first and second profile ends.

2. The system as set forth in claim 1 wherein said plurality of reinforcing ribs define a plurality of pockets varying in quantity as said plurality of reinforcing ribs extend longitudinally between said first profile end and said second profile end.

3. The system as set forth in claim 2 wherein said at least one intermediate rib includes a plurality of intermediate reinforcing ribs disposed between said top reinforcing rib and said bottom reinforcing rib with each one of said plurality of intermediate reinforcing ribs extending longitudinally and non-linearly between said first and second profile end and adjacent intermediate reinforcing ribs of said plurality of intermediate reinforcing ribs converging with one another at said first profile end and said second profile end.

4. The system as set forth in claim 3 wherein said plurality of intermediate reinforcing ribs includes a first intermediate reinforcing rib disposed adjacent said top reinforcing rib, a

13

second intermediate reinforcing rib disposed adjacent said bottom reinforcing rib, and a third intermediate reinforcing rib disposed between said first and said second intermediate reinforcing rib, and

wherein said plurality of pockets includes a first pocket of generally rectangular cross-sectional shape disposed between said top reinforcing rib and said first intermediate reinforcing rib, a second pocket of generally rectangular cross-sectional shape disposed between said second intermediate reinforcing rib and said bottom reinforcing rib, a third pocket of elongated hexagonal cross-sectional shape disposed between said first intermediate reinforcing rib and said third intermediate reinforcing rib, a fourth pocket of elongated hexagonal cross-sectional shape disposed between said third intermediate reinforcing rib and said second intermediate reinforcing rib, a pair of fifth pockets of triangular cross-sectional shape each disposed adjacent respective said first and second profile ends and between said converging portions of said intermediate reinforcing ribs.

5. The system as set forth in claim 1 further comprising: said front panel of said bumper beam including a front center portion disposed between a pair of front side portions, said back panel of said bumper beam including a back center portion disposed between a pair of back side portions, said front center portion has a front center portion thickness being greater than a back center portion thickness of said back center portion, and each of said front side portions having a front side portion thickness being less than a back side portion thickness of said back side portions.

6. The system as set forth in claim 5 wherein said front center portion thickness is greater than said front side portion thickness and said back center portion thickness being less than said back side portion thickness.

7. The system as set forth in claim 1 further including a pair of crush boxes integrally cast with and extending outwardly from said back panel.

8. The system as set forth in claim 7 wherein each of said crush boxes having a body including a top wall and a bottom wall and a pair of side walls extending between said top wall and said bottom wall, and

said side walls including a first side wall having a first side wall thickness and a second side wall having a second side wall thickness and with said first side wall thickness being greater than said second side wall thickness.

9. The system as set forth in claim 8 wherein said top wall has a variable top wall thickness between said first and second side walls and said bottom wall has a variable bottom wall thickness between said first and second side walls.

10. The system as set forth in claim 9 wherein said variable top wall thickness is equal to said first side wall thickness adjacent said first side wall and decreases to be equal to said second side wall thickness adjacent said second side wall, and said variable bottom wall thickness is equal to said first side wall thickness adjacent said first side wall and decreases to be equal to said second side wall thickness adjacent said second side wall.

11. The system as set forth in claim 8 wherein each of said crush boxes further includes a reinforcing plate integrally cast extends in spaced relationship with said top wall and said bottom wall and between said pair of side walls.

14

12. The system as set forth in claim 11 wherein said reinforcing plate has a variable reinforcing plate thickness between said pair of side walls.

13. The bumper system as set forth in claim 12 wherein said reinforcing plate includes at least one internal reinforcing rib to define said variable reinforcing plate thickness.

14. The system as set forth in claim 8 wherein said top wall and said bottom wall each define at least one buckle initiating grooves integrally cast with said top wall and said bottom wall.

15. A bumper system comprising:

a bumper beam being cast from metal and having a front panel and a back panel extending in spaced relationship to one another between a first bumper beam end and a second bumper beam end,

said front panel of said bumper beam including a front center portion disposed between a pair of front side portions,

said back panel of said bumper beam including a back center portion disposed between a pair of back side portions,

said front center portion having a front center portion thickness being greater than a back center portion thickness of said back center portion, and each of said front side portions having a front side portion thickness being less than a back side portion thickness of adjacent one of said back side portions;

a plurality of reinforcing ribs integrally cast with said bumper beam and extending between said front panel and said back panel for providing structural rigidity to said bumper beam; and

said plurality of reinforcing ribs including a top reinforcing rib and a bottom reinforcing rib disposed in spaced relationship to one another and extending longitudinally and linearly between a first profile end disposed relative to said first bumper beam end and a second profile end disposed relative to said second bumper beam end and at least one intermediate rib disposed between said top and bottom reinforcing rib and extending longitudinally and non-linearly between said first and second profile ends to define a non-uniform cross-sectional profile of said bumper beam taken along a plane disposed perpendicular to said plurality of reinforcing ribs and extending between said first and second profile ends.

16. The system as set forth in claim 15 wherein said front center portion thickness is greater than said front side portion thickness of said front side portions and said back center portion thickness being less than said back side portion thickness of said back side portions.

17. The system as set forth in claim 15 wherein said plurality of reinforcing ribs define a plurality of pockets varying in quantity as said plurality of reinforcing ribs extend longitudinally between said first profile end disposed and said second profile end.

18. The system as set forth in claim 17 wherein said at least one intermediate rib includes a plurality of intermediate reinforcing ribs disposed between said top reinforcing rib and said bottom reinforcing rib with each one of said plurality of intermediate reinforcing ribs extending longitudinally and non-linearly between said first and second profile end and adjacent intermediate reinforcing ribs of said plurality of intermediate reinforcing ribs converging with one another at said first profile end and said second profile end to define said non-uniform cross-section.

19. The system as set forth in claim 18 wherein said plurality of intermediate reinforcing ribs includes a first

15

intermediate reinforcing rib disposed adjacent said top reinforcing rib, a second intermediate reinforcing rib disposed adjacent said bottom reinforcing rib, and a third intermediate reinforcing rib disposed between said first and said second intermediate reinforcing rib, and

wherein said plurality of pockets includes a first pocket of generally rectangular cross-sectional shape disposed between said top reinforcing rib and said first intermediate reinforcing rib, a second pocket of generally rectangular cross-sectional shape disposed between said second intermediate reinforcing rib and said bottom reinforcing rib, a third pocket of elongated hexagonal cross-sectional shape disposed between said first intermediate reinforcing rib and said third intermediate reinforcing rib, a fourth pocket of elongated hexagonal cross-sectional shape disposed between said third intermediate reinforcing rib and said second intermediate reinforcing rib, a pair of fifth pockets of triangular cross-sectional shape each disposed adjacent respective said first and second profile ends and between said converging portions of said intermediate reinforcing ribs.

20 **20.** A method for manufacturing a bumper system, said method comprising:

metal casting a bumper beam having a front panel and a back panel extending in spaced relationship to one another between a first bumper beam end and a second bumper beam end and a plurality of reinforcing ribs

16

extending between the front panel and the back panel and defining a non-uniform cross-sectional profile along at least a portion of the bumper beam; and metal casting a pair of crush boxes integrally with the bumper beam extending outwardly from said back side portions of said back panel, each of said crush boxes having a body including at least one buckle initiating groove on both a top wall and a bottom wall and at least one internal reinforcing rib on a pair of side walls extending between said top wall and said bottom wall, and at least one reinforcing rib on a reinforcing plate disposed on each of said crush boxes in spaced relationship between said respective top wall and said bottom wall and extending between said respective pair of side walls connecting said side walls with one another.

25 **21.** The method as set forth in claim **20** wherein said step of metal casting the bumper beam further including a step of forming the front panel including a front center portion disposed between a pair of front side portions and the back panel including a back center portion disposed between a pair of back side portions with the front center portion having a front center portion thickness being greater than a back center portion thickness of the back center portion, and each of the front side portions having a front side portion thickness being less than a back side portion thickness of adjacent one of the back side portions.

* * * * *